

LSF56 x LSW-EM12K



LINKWELD ALLOYS INC.

AWS
JIS

A5.17 F7A2-EM12K
Z3183 S502-H

Characteristics:

LSF-56 is a neutral flux. It is designed for multi-pass groove welds. With nice bead appearance, porosity resistance and good slag removability. High welding efficiency, good toughness can be obtained. It produces good impact property and minimum 500N/mm² tensile strength when used with LSW-EM12K.

Applications:

Typical applications include pressure vessels, shipbuilding and general steel structure.

Notes on Usage:

1. Dry the flux at 350°C for 60 minutes before use.
2. When performing first pass welding, it is recommended to use lower current to prevent cracking.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.08	1.60	0.53	0.019	0.015

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL%	IV J	
460	560	29	-30°C	-40°C
			55	40

Sizes available, Package:

Wire: Diameter (mm)	2.4	3.2	4.0
Wire: Weight per roll (kg)	25	25	25
Flux: Weight per bag(kg)	25	25	25