

Lincolnweld® 888™

EN 760 – S A Z • 800 Series Neutral Flux

Recommended Wires

For Mild Steel

Lincolnweld® L-50®, L-56®, L-S3, L-61®, LA-71

For Low Alloy Steel

Lincolnweld® L-70, LA-75, LA-82, LA-84, LA-85,
LA-90, LA-100, LAC-Ni2, LAC-M2, LAC-B2, LAC-690

Product Information

Basicity Index: 2.2

Density: 1.3 g/cm³

Packaging

50 lb (22.7 kg) Plastic Bag

ED031596

Key Features

- ▶ Designed for deep groove slag removal in critical applications
- ▶ Low H4 diffusible hydrogen levels
- ▶ Moisture resistant packaging
- ▶ Charpy V-Notch and CTOD test results available for most alloy systems

Typical Applications

- ▶ Excellent operation with multiple arcs
- ▶ Structural fabrication
- ▶ Shipbuilding
- ▶ Offshore

FLUX COMPOSITION⁽¹⁾

	%SiO ₂	%MnO	%MgO	%CaF ₂	%Na ₂ O	%Al ₂ O ₃	%CaO	%FeO	%K ₂ O	% Metal Alloys
Lincolnweld® 888™	18	1	27	25	2	19	5	1	2	3 max.

AWS TEST RESULTS⁽¹⁾

Flux/Wire Combination	Weld Condition	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation (%)	Charpy V-Notch J (ft•lbf)	@ °C (°F)	AWS Classification (A5.17/A5.23)
L-50®	As-welded	430 (62)	540 (78)	31	122 (90)	-62 (-80)	F7A8-EM13K-H4
L-50®	Stress-relieved ⁽³⁾	370 (53)	510 (74)	32	187 (138)	-62 (-80)	F6P8-EM13K-H4
L-56®	As-welded	510 (74)	610 (88)	29	71 (52)	-51 (-60)	F8A6-EH11K-H4
L-56®	Stress-relieved ⁽³⁾	410 (59)	540 (79)	32	118 (87)	-62 (-80)	F7P8-EH11K-H4
L-61®	As-welded	420 (61)	520 (75)	31	121 (89)	-51 (-60)	F7A6-EM12K-H4
L-S3	As-welded	480 (70)	570 (83)	33	70 (52)	-62 (-80)	F7A8-EH12K-H4
L-S3	Stress-relieved ⁽³⁾	370 (54)	510 (74)	33	165 (122)	-62 (-80)	F6P8-EH12K-H4
LA-71	As-welded	520 (75)	610 (89)	28	68 (50)	-51 (-60)	F7A6-EM14K-H4
LA-71	Stress-relieved ⁽³⁾	410 (60)	540 (78)	32	134 (99)	-62 (-80)	F7P8-EM14K-H4
L-70	As-welded	510 (74)	600 (87)	29	60 (45)	-40 (-40)	F7A4-EA1-A2-H4
L-70	Stress-relieved ⁽³⁾	470 (69)	570 (83)	31	126 (93)	-40 (-40)	F7P4-EA1-A2-H4
LA-75	As-welded	470 (68)	580 (84)	31	122 (90)	-62 (-80)	F7A8-ENi1K-Ni1-H4
LA-82	As-welded	690 (99)	780 (113)	23	70 (52)	-62 (-80)	F10A8-EF2-F2-H4
LA-82	Stress-relieved ⁽³⁾	600 (87)	700 (102)	25	79 (58)	-51 (-60)	F9P6-EF2-F2-H4
LA-84	As-welded	630 (92)	720 (105)	23	77 (57)	-62 (-80)	F9A8-EF3-F3-H4
LA-84	Stress-relieved ⁽³⁾	580 (84)	670 (98)	26	34 (25)	-51 (-60)	F8P6-EF3-F3-H4
LA-85	As-welded	540 (78)	640 (92)	26	79 (58)	-51 (-60)	F8A6-ENi5-Ni5-H4
LA-85	Stress-relieved ⁽³⁾	500 (72)	590 (86)	27	76 (56)	-51 (-60)	F7P6-ENi5-Ni5-H4
LA-90	As-welded	610 (89)	700 (102)	26	56 (41)	-51 (-60)	F9A6-EA3K-A3-H4
LA-100	As-welded	690 (100)	760 (111)	25	61 (45)	-40 (-40)	F10A4-EM2-M2-H4
LAC-B2	Stress-relieved ⁽⁴⁾	520 (76)	620 (90)	24	82 (60)	-40 (-40)	F8P4-ECB2-B2-H8
LAC-M2	As-welded	860 (124)	930 (135)	15	63 (46)	-62 (-80)	F12A8-ECG-G-H8
LAC-Ni2	As-welded	540 (78)	630 (92)	20	56 (42)	-62 (-80)	F8A8-ECNi2-Ni2-H8
LAC-Ni2	Stress-relieved ⁽³⁾	480 (70)	580 (84)	27	64 (47)	-73 (-100)	F7P10-ECNi2-Ni2-H8
LAC-690	As-welded	800 (116)	860 (124)	22	91 (67)	-73 (-100)	F11A10-ECG-G-H4
LAC-690	Stress-relieved ⁽³⁾	707 (103)	776 (113)	21	51 (37)	-51 (-60)	F11P6-ECG-G-H4

⁽¹⁾See test results disclaimer below. ⁽²⁾Measured with 0.2% offset. ⁽³⁾Stress-relieved for 1 hour at 621°C (1150°F). ⁽⁴⁾Stress-relieved for 1 hour at 691°C (1275°F).
NOTE: For the most up-to-date AWS certificates of conformance please visit www.lincolnelectric.com