

LINCOLNWELD® 888™

800 Series Neutral Flux ■ EN ISO 14174 – S A Z

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
- Actual (Type 3.1) certificates for each lot of flux showing chemical composition, particle size and moisture level are available in the certificate center of lincolnelectric.com

PACKAGING

50 lb (22.7 kg) Plastic Bag
2600 lb (1179 kg) Bulk Bag

ED031596
ED033490

RECOMMENDED WIRES

Mild Steel

Lincolnweld® L-50®, L-56®, L-53, L-61®, LA-71

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

TYPICAL APPLICATIONS

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

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		AWS Classification (A5.17/A5.23)
					J (ft•lbf)	@ °C (°F)	
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-53	As-welded	480 (70)	570 (83)	33	70 (52)	-62 (-80)	F7A8-EH12K-H4
L-53	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-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. ⁽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