

Lincolnweld® L-60

Key Features:

- ▶ Low carbon, low manganese, low silicon general purpose SAW wire
- ▶ Typical applied in single or limited pass welding on rust base material
- ▶ It provides the lowest hardness and is best suited for use with the PREMIERWELD® 700 series of active fluxes.

Recommended Fluxes:

- ▶ PREMIERWELD® AF-5, PREMIERWELD® 761, PREMIERWELD® 780

Conformance:

- ▶ ASME SFA-5.17 AWS A5.17: EL12

Welding Positions:

- ▶ Horizontal & Flat welding

Chemical Composition -- Solid Wire (Wt %), Typical

Wire	C	Mn	Si	P	S
Requirements - AWS EL12	0.04-0.14	0.25-0.60	≤0.10	≤0.030	≤ 0.030
Lincolnweld® L-60	0.098	0.46	0.06	0.008	0.005

Mechanical Properties -- All Weld Metal, Typical

Wire / Flux	Condition	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation[%]	CVN Impact J(ft·lbf) @ °C(°F)	Classification
Lincolnweld® L-60/ PREMIERWELD® 761	As-welded	425 [62]	515 [75]	24	62 [46] -29[-20]	AWS:F7A2-EL12
Lincolnweld® L-60/ PREMIERWELD® 780	As-welded	420 [61]	515[75]	30	58 [43] 0[Z]	AWS:F7AZ-EL12

Recommended Welding Parameters (DC+,AC)

Diameter (mm)	2.0	2.4	3.2	4.0	4.8
Current Range (A)	300-400	350-450	425-525	475-575	525-625
Voltage (V)	26-29	27-30	27-30	27-30	27-30
ESO (mm)	13-19	19-32	25-38	25-38	25-38
Travel Speed (mm/s)	5-6	5.5-6.5	6-7	6.5-7.5	6.5-7.5

The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory.

Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page.

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