

LINCOLN® SHS® 9800U

Severe Abrasion

KEY FEATURES

- Exceptional resistance to severe sliding abrasion
- Provides longer lasting wear life than most chrome carbide and complex carbide alloys
- Improved impact resistance results from complex borocarbide phases surrounded by ductile phases that form during welding
- Limited to 2 layers max

TYPICAL APPLICATIONS

- Wearplate
- ID Clad Pipe
- Slurry Transport
- Crusher Rolls
- Ore Chutes
- Screw Augers

DIAMETERS / PACKAGING

Diameter in (mm)	33 lb (15 kg) Spool PLW	50 lb (22.7 kg) Fiber Spool PLW	55 lb (25 kg) Coil	280 lb (127 kg) Drum	400 lb (181 kg) Speed Feed Drum	500 lb (227 kg) Speed Feed Drum
0.045 (1.1)	ED035650	ED035858	ED035646 ED035645	ED035973	ED035859	ED035860 ED035924
1/16 (1.6)	ED035648					
3/32 (2.4)						
7/64 (2.8)						

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R _c)	Wear Resistance
68-71	ASTM G65-04 Procedure A, 0.12 g mass loss

DEPOSIT COMPOSITION⁽¹⁾

%Fe	%C	%Cr	%B	%Mo	%Nb	%Mn	%Si
Balance	<2	<21	<7	<6	<6	<2	<2

TYPICAL OPERATING PROCEDURES

Diameter, Polarity ESO - in (mm)	Current (Amps)	Voltage (Volts)	Wire Feed Speed m/min (ipm)	Shielding Gas	Flow Rate (cfh)
0.045 in (1.1mm), DC+ ½ - ¾ (15) GMAW-C ¾ - 1 (20) FCAW-S	~135	24	7.0 (275)	75 Ar - 25 CO ₂	35 - 45
1/16 in (1.6mm), DC+ ½ - ¾ (15) GMAW-C ¾ - 1 (20) FCAW-S	~220	24	7.0 (275)	75 Ar - 25 CO ₂	45 - 60
3/32 in (2.4mm), DC+ ¾ - 1 (20) GMAW-C ¾ - 1.25 (25) FCAW-S	~375	25	7.0 (275)	75 Ar - 25 CO ₂	55 - 70
7/64 in (2.8mm), DC+ ¾ - 1 (20) GMAW-C 1 - 1½ (40) FCAW-S	~450	26	5.7 (225)	75 Ar - 25 CO ₂	60 - 80

⁽¹⁾ Composition and properties depend upon dilution. Single layer deposit properties depend upon base metal and/or build-up material.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.