

# Lincore® M

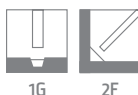
## Key Features

- Self-shielded open arc cored wire
- Deposit resists severe impact as well as moderate abrasion
- Produces an austenitic manganese deposit that work-hardens
- Unlimited layers with proper preheat and interpass temperatures and procedures
- Recommended for build-up and repair of Hadfield-type austenitic manganese materials as well as carbon and low alloy steels

## Typical Applications

- Rail crossover
- Crusher hammers
- Dredge parts
- Crusher rolls
- Breaker bars
- Buckets

## Welding Positions



## Conformances

**AS/NZS 2576:** 1220 B7\*  
(nearest equivalent)

## Diameter / Packaging

Diameter mm	Part Number	Packaging
1.6	ED031129	Steel spool 11.3 kg
2.0	ED031130	Steel spool 11.3kg
2.8	ED011164	Coil 22.7kg

## Mechanical Properties

Rockwell - HRc	
As Welded	Work Hardened
18-28	30-48

## Deposit Composition

	%C	%Mn	%Si	%Cr	%Ni
Open Arc (2 layers)	0.60	13.0	0.4	4.9	0.5

## Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.6 mm, DC+, 30 mm	150	23	130	2.2
	250	25	200	3.9
	350	27	250	5.6
2.0 mm, DC+, 32 mm	125	24	240	2.9
	175	27	300	4.2
	250	29	360	6.2
2.8 mm, DC+, 45 mm	75	25	240	3.5
	125	27	360	6.2
	150	28	395	7.5
2.8 mm, DC+, 64 mm	75	25	240	3.6
	175	30	400	8.8
	225	32	455	11.6

**NOTE:** As with all austenitic manganese welding products, interpass temperatures should be limited to 260°C maximum. A stringer bead, or at most, a slight weave is recommended to limit heat build-up. Excessive heat build-up causes manganese carbide precipitation which damages the toughness of austenitic manganese.