

Lincore[®] 42-S

Key Features

- Designed for rebuilding heavy equipment undercarriages
- The deposit exhibits enhanced crack resistance and toughness compared to Lincore[®] 40-S
- Designed to resist rolling and sliding metal-to-metal wear
- For automatic and semi-automatic operation

Typical Applications

- Tractor rollers
- Tractor idlers
- Track pads

Conformances

AS/NZS 2576: 1440 B1*
(nearest equivalent)

Recommended Flux

- Lincolnweld[®] 802, 880

Diameter / Packaging

Diameter mm	Part Number	Packaging
3.2	ED029264	Speed-Feed [®] Drum 136kg

Mechanical Properties

Rockwell – HRC	
1 Layer	38 - 40

Deposit Composition

With Recommended Neutral Flux	%C	%Mn	%Si	%Cr	%Mo
3.2 mm Diameter (20 mm ESO)					
1 Layer	0.14	2.13	0.34	1.45	0.43
2 Layers	0.12	2.70	0.39	2.22	0.66
4 Layers	0.11	3.33	0.44	2.95	0.84
3.2 mm Diameter (40 mm ESO)					
1 Layer	0.14	2.49	0.33	2.02	0.60
2 Layers	0.13	3.05	0.42	2.96	0.84
4 Layers	0.13	3.41	0.47	3.15	0.99

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
3.2 mm, DC+, 20 mm	50	27	350	3.8
	100	28	565	7.5
	125	29	675	9.3
3.2 mm, DC+, 40 mm	50	27	325	3.8
	100	28	510	7.5
	125	29	605	9.4