

# Lincore® T & D

## Key Features

- Self-shielded open arc cored wire
- Delivers a deposit similar to H12 tool steel
- For build-up of tool steel dies and edges, or applying wear resistance surfaces on carbon or low alloy steels

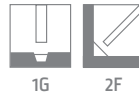
## Typical Applications

- Punch dies
- Shear blades
- Cutting tools and trimmers

## Conformances

AS/NZS 2576: 1550 B7\*  
(nearest equivalent)

## Welding Positions



## Diameter / Packaging

Diameter mm	Part Number	Packaging
1.6	ED031134	Spool - Steel 11.3kg

## Mechanical Properties

Rockwell - HRc	
As Welded	Heat treated at 540°C
48-55	55-65

## Deposit Composition

	%C	%Mn	%Si	%Al	%Cr	%Mo	%W
6 Layers Open Arc	0.65	1.5	0.8	1.8	7.0	1.4	1.6

## Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.6 mm, DC+, 32 mm	150	22	170	2.4
	200	23	210	3.6
	250	24	250	4.1
	300	25	270	4.9
	350	26	300	5.4

**NOTE:** Minimum preheat and interpass temperatures of 315°C are essential for crack-free welding on mild steel or low alloy steel. For crack-free welding on tool steel parts, preheat of 538°C or higher may be necessary. After welding, very slow cooling to 120°C is usually required. This can be followed by post-weld heat treating at 538°-593°C to develop maximum hardness.