

Lincore® 33

Key Features

- Self-shielded flux cored wire
- Delivers tough machinable deposits for build-up or final overlay intended for metal-to-metal wear
- Ideal for rebuilding worn parts to near final dimensions before applying final hardfacing layers which are more wear resistant
- Unlimited layers with proper preheat and interpass temperatures and procedures

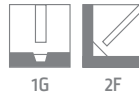
Typical Applications

- Tractor rolls and idlers
- Shovel parts
- Mine car wheels
- Mill and crusher hammers
- Dredge pumps

Conformances

AS/NZS 2576: 1130 B1/B7*
(nearest equivalent)

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.6	ED031117	Steel Spool 11.34kg
2.0	ED011237	Coil 6.35kg – Master Carton 25.4kg
	ED011238	Coil 22.7kg
2.8	ED011240	Coil 22.7kg

Mechanical Properties

Number of Layers	Rockwell - HRC		
	As Welded	Work Hardened	Flame Hardened / Water Quenched
1	14-30	28-34	-
2	26-32	32-36	38-42
3	25-34	35-38	-

Deposit Composition

	%C	%Mn	%Si	%Al	%Cr
3 Layers (1.6 mm)	0.11-0.18	1.8-2.1	0.50-0.75	1.6-1.9	1.2-1.4
3 Layers (2.0 and 2.8 mm)	0.13-0.15	2.1-2.3	0.45-0.60	1.45-1.70	1.1-1.4

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.6 mm, DC+, 45 mm	150	26	125	2.1
	250	29	180	3.5
	350	32	225	5.0
2.0 mm, DC+, 50 mm	125	23	200	3.1
	200	27	290	4.9
	250	29	325	6.1
2.8 mm, DC+, 64 mm	135	26	360	5.7
	175	28	420	7.3
	235	30	470	9.6