

# Lincore® 33

## TOP FEATURES

- Build-up deposit on carbon steel and low alloy steel base metals
- Unlimited layers
- Delivers tough machinable deposits for build-up or final overlay intended for metal-to-metal wear

## TYPICAL APPLICATIONS

- Build-up deposit on carbon steel and low alloy steel base metals

## CLASSIFICATION

EN ISO T Fe1

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat/Horizontal

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Al
0.15	2.0	0.7	2.0	1.6

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Layer	Typical hardness values
1	21-30 HRc (230-290 HB)
2	26-32 HRc (260-300 HB)
3	28-34 HRc (250-330 HB)

Welded on Mild Steel Plate (12mm)

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.1	SPOOL	11.3	ED031116
1.6	SPOOL	11.3	ED031117
2.0	COIL	6.4	ED011237
	SPOOL	11.3	ED031118
2.8	COIL	22.7	ED011238
	COIL	22.7	ED011240

## ADDITIONAL INFORMATION

- All work-hardened base material should be removed prior to applying Lincore 33 to prevent embrittlement and cracking.
- Preheat and postweld heat treatment is not generally necessary on C/Mn steels, however, preheat up to 260°C may be necessary on high carbon steels or large complex or restrained components.
- The deposited weld metal can be machined to exact dimensions using high speed or carbide cutting tools.
- There is no limit to the deposit build-up with this electrode.

### 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

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.