Lincore® 60-O

TOP FEATURES

- To be used on carbon, low alloy, manganese and stainless steels and cast iron
- Deposit is limited to two layers
- Deposits feature higher alloy levels than to resist both abrasion and moderate impact

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

TYPICAL APPLICATIONS

- Bucket lips
- Crusher hammers
- Ore chutes
- Dozer blades
- Ripper Teeth

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

C	Mn	Si	Cr	Al
4.2	1.6	1.3	25.4	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Layer	Typical hardness values
1	55 - 60 HRc
2	58 - 60 HRc

Welded on Mild Steel Plate (12mm)

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.1	SPOOL	4.5	ED037262
	SPOOL	11.3	ED031131
1.6	SPOOL	4.5	ED037263
	SPOOL	11.3	ED031132
2.0	SPOOL	11.3	ED031133
	COIL	22.7	ED019887
	DRUM	227.0	ED037493
2.8	COIL	22.7	ED019888

ADDITIONAL INFORMATION

- When welding with Lincore 60-O stringer beads should be employed. Weaving is not advised since wide weaves generally increase the check crack spacing which can result in deposit spalling.
- Preheat is not necessary when surfacing austenitic substrates such as stainless steels and manganese steels, although the interpass temperature should be limited to about 260°C for manganese steels. For low alloy and high carbon steels a preheat of 200°C is necessary to prevent heat affected zone cracking.
- The weld metal is not machinable or forgeable and it readily check cracks. The deposit thickness is usually limited to 2 layers, as excessive build-up will result in chipping and fragmentation.
- For applications requiring build-ups in excess of 2 layers, buttering layers of Lincore 33, Wearshield BU30 or RepTec 126.
- Alternatively, a preheat of 650°C can be used to eliminate the formation of check cracks.

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 for any updated information.