

Lincoln® SHS 9800U

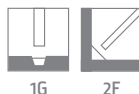
Key Features

- Open arc self-shielded cored wire
- Exceptional resistance to severe sliding abrasion
- Longer lasting wear life than most chrome carbide and complex carbide alloys
- Improved impact resistance results
- Deposit is limited to two layers

Typical Applications

- Wear plate manufacture
- Ore chutes
- Crusher rolls
- Screw augers
- Slurry transport
- ID clade pipe

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.1	ED035650	Spool PLW 15kg
1.6	ED035648	Spool PLW 15kg

Mechanical Properties

Rockwell - HRC

68-71

Deposit Composition

	%C	%Mn	%Si	%Al	%Cr
2 Layers – Open Arc	< 2	< 2	< 2	< 5	< 21
	%B	%Mo	%Nb	%Fe	
2 Layers – Open Arc	< 7	< 6	< 6	Balance	

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps
1.1 mm, DC+, 20 mm	275	24	135
1.6 mm, DC+, 20 mm	275	24	220

NOTE: Deposit thickness limit is two layers unless high travel speed is used to obtain very closely spaced check cracks. Many layers can be used with high travel speed and small bead sizes to ensure close-spaced check cracks. Lincoln® SHS 9800U deposit cross cracks (commonly called relief-checking) on cooling. This is desirable, since cross-cracking of the deposit relieves cooling stresses and prevents spalling.