

Lincoln® SHS 9192U

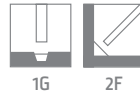
Key Features

- Open arc self-shielded cored wire
- Extreme resistance to abrasion
- Maintains high hardness after exposure to elevated temperatures
- Provides exceptional uniformity of hardness and wear across a wide range of service environments
- Deposit is limited to two layers

Typical Applications

- Wear plate manufacture
- Ore chutes
- Crusher rolls
- Screw augers

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.1	ED035663	Coil 15kg
1.6	ED037277	Spool PLW 15kg

Mechanical Properties

Rockwell - HRc

69-72

Deposit Composition

	%C	%Mn	%Si	%Al	%Cr
2 Layers – Open Arc	< 5	< 5	< 2	< 5	< 20
	%W	%B	%Mo	%Nb	%Fe
2 Layers – Open Arc	< 10	< 5	< 10	< 10	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 9192U deposit cross cracks (commonly called relief-checking) on cooling. This is desirable, since cross-cracking of the deposit relieves cooling stresses and prevents spalling.