

Lincore[®] 55-G (continued)

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.1 mm, DC+, 16 mm 75% Ar / 25% CO ₂	200	27	165	2.0
	300	29	225	3.0
	400	31	290	4.2
1.1 mm, DC+, 20 mm 98% Ar / 2% O ₂	200	25	145	2.3
	300	27	200	3.4
	350	28	225	3.9
	400	29	250	4.4
1.6 mm, DC+, 16 mm 75% Ar / 25% CO ₂	150	28	260	2.6
	250	30	340	4.7
	350	32	420	6.8
1.6 mm, DC+, 20 mm 98% Ar / 2% O ₂	150	24	220	2.9
	250	26	315	5.0
	350	28	410	7.1

NOTE: Work area should be clean, with any previous hardfacing deposit removed, and cracks properly repaired. Cold parts should be warmed to at least 250°C. Higher preheat of 150° - 260°C on thick parts or heavy sections.