

PRODUCT FAMILY HARDNESS

Category			Abrasion resistance				Rockwell Hardness			Gas		Base Material					Weld process		Weld Position			
Severe Abrasion with Low Impact (Metal-to-Earth)	Abrasion & Impact	Metal To Metal	ASTM G65 mass loss (grams)	Layers	Check Cracking	Slag	at 1 Layer	at 2 Layers	at 4 Layers	75-90% Argon / Balance CO ₂	98% Argon / 2% O ₂	Carbon Steel	Cast Iron	Low Alloy	Manganese	Stainless Steel	GMAW-C	FCAW-S	Flat	Horizontal	Vertical	
	Lincore® 50		0.8 g	4	Yes	No	43	50	53			•		•	•	•		•	•	•	•	
		Lincore® 55	1.5 g	100+	No*	Yes	51	54	55			•		•				•	•	•	•	
		Lincore® 55-G	1.5 g	100+	No*	No				Yes	Yes	•		•			•		•	•	•	•
	Lincore® 57-G		0.44 g	4	No*	No	55	57	55	Yes	Yes	•		•			•		•	•	•	
	Lincore® 60-G		0.15g	2	Yes	No	58	60		Yes	Yes	•	•	•	•		•		•	•	•	
	Lincore® 60-O		0.18 g	2	Yes	No	55	60				•	•	•	•	•		•		•	•	
	Lincore® 65-O		0.15g	4	Yes	No	57	60	64			•	•	•	•	•		•		•	•	
	Lincore® 70-G		0.12 g	2	Yes	No	67	70	N/A	Yes		•		•			•		•	•	•	
	Lincoln® SHS® 9500U		0.22 g	2	No*	No	58	62	N/A	Yes		•		•			•		•	•	•	
	Lincoln® SHS® 9700U		0.13 g	2	Yes	No	67	70	N/A	Yes		•		•			•		•	•	•	
	Lincoln® SHS® 9800U		0.12 g	2	Yes	No	68	71	N/A	Yes		•		•			•		•	•	•	
	Lincoln® SHS® 9192U		0.10 g	2	Yes	No	69	72	N/A	Yes		•		•			•		•	•	•	

Test Results Disclaimer

Test results for hardness testing were obtained from a weld produced and tested according to prescribed standards. Actual results will vary depending on many factors, including, but not limited to: the base material or substrate being welded, the welding procedure and welding process, and the unique conditions present in the workplace or welding environment. Users and employers have the sole responsibility for and control over workplace conditions, including the manner in which work is performed and the safety measures taken. Always read and follow applicable OSHA regulations as well as all information on product labeling and safety data sheets when using Lincoln Electric products. Safety data sheets for Lincoln Electric products can be found at www.lincolnelectric.com/en-us/support/msds/Pages/sds-search.aspx. Users and employers should have an industrial hygienist check worker exposure levels to be certain