

Lincore® 15CrMn

Key Features

- Self-shielded open arc cored wire
- Provides an austenitic manganese deposit which exhibits very good crack resistance
- Unlimited layers with proper preheat and interpass temperatures and procedures

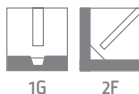
Conformances

AS/NZS 2576: 1720 B7*
(nearest equivalent)

Typical Applications

- Spreader cones
- Crusher hammers
- Austenitic manganese parts
- Work-hardens for overlay or joining austenitic manganese steel to itself or to carbon steel
- Can be used as a build-up layer before capping with abrasion resistant alloys

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
2.0	ED031126	Steel Spool 11.3kg
2.8	ED022061	Coil 22.7kg

Mechanical Properties

Rockwell - HRC	
As Welded	Work Hardened
18-22	40-50

Deposit Composition

	%C	%Mn	%Si	%Cr
6 Layers Open Arc	0.4	15.0	0.2	16.0

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
2.0 mm, DC+, 32 mm	125	26	210	3.3
	200	29	280	5.3
	250	30	320	6.8
	350	32	380	9.7
2.8 mm, DC+, 45 mm	75	26	250	2.5
	125	28	320	5.1
	150	29	350	6.6
	175	30	380	7.5
2.8 mm, DC+, 64 mm	150	30	320	6.7
	200	33	390	8.7
	225	34	410	9.8
	250	35	425	11.4

NOTE: As with all austenitic manganese welding products, interpass temperatures should be limited to 260°C maximum. A stringer bead, or at most, a slight weave is recommended to limit heat build-up. Excessive heat build-up causes manganese carbide precipitation which damages the toughness of austenitic manganese.