

Lincore® 60-0

Severe Abrasion • EN 760 – S A AB 1

Key Features

- ▶ Deposits feature higher alloy levels than to resist both abrasion and moderate impact
- ▶ Can be used at temperatures up to 704°C (1300°F)
- ▶ To be used on carbon, low alloy, manganese, stainless steels and cast iron
- ▶ Deposit is limited to two layers

Typical Applications

- ▶ Bucket lips
- ▶ Crusher hammers
- ▶ Ore chutes
- ▶ Dozer blades
- ▶ Ripper teeth

Welding Positions

Flat & Horizontal

DIAMETERS / PACKAGING

Diameter in (mm)	25 lb (11.3 kg) Steel Spool	50 lb (22.7 kg) Coil
0.045 (1.1)	ED031131	ED019887 ED019888
1/16 (1.6)	ED031132	
5/64 (2.0)	ED031133	
7/64 (2.8)		

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R _c)
55-60

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%Al	%Cr
2 Layers Open Arc	3.7 - 4.3	0.8 - 0.9	0.8 - 1.0	0.3 - 0.4	20.0 - 21.3
2 Layers w/ 802 Flux	3.6 - 4.0	1.0 - 1.1	1.0 - 1.1	0.2 - 0.3	17.4 - 18.5

TYPICAL OPERATING PROCEDURES

Diameter, Polarity ES0 - in (mm)	Wire Feed Speed m/min (in/min)	Voltage (Volts)	Approx. Current (Amps)	Deposition Rate kg/hr (lb/hr)
0.045 in (1.1mm), DC+ 1 (25)	5.1 (200)	21	125	1.9 (4.1)
	10.2 (400)	25	185	3.7 (8.2)
	12.7 (500)	27	210	4.7 (10.3)
1/16 in (1.6 mm), DC+ 7/8 (22)	5.1 (200)	28	240	3.4 (7.6)
	7.6 (300)	31	300	5.1 (11.2)
	11.4 (450)	33	350	7.5 (16.6)
5/64 in (2.0 mm), DC+ 1-1/4 (32)	3.2 (125)	26	250	3.4 (7.4)
	5.1 (200)	30	350	5.4 (12.0)
	6.4 (250)	32	400	6.9 (15.1)
7/64 in (2.8 mm), DC+ 1-1/8 (30)	1.9 (75)	27	250	3.4 (7.4)
	3.2 (125)	30	340	5.4 (11.9)
	4.4 (175)	32	420	7.5 (16.5)
With Recommended Neutral Fluxes 7/64 in (2.8 mm), DC+ 1-1/8 (30)	2.5 (100)	30	295	4.4 (9.6)
	3.2 (125)	32	340	5.4 (11.9)
	4.4 (175)	34	420	7.5 (16.5)

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. Lincore® 60-0 deposit cross cracks (commonly called cross-checking) on cooling. This is desirable, since cross-cracking of the deposit relieves cooling stresses and prevents spalling.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume. BEFORE USE, READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

⁽¹⁾ Composition and properties depend upon dilution. Single layer deposit properties depend upon base metal and/or build-up material.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

THE LINCOLN ELECTRIC COMPANY
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
Phone: +1.216.481.8100 • www.lincolnelectric.com

