

LINCORE® 420HC-S

Roll Rebuilding, Metal-to-Metal

KEY FEATURES

- Metal-cored wire which produces a high carbon, 420 stainless steel deposit
- Use where a higher hardness is required
- Used on rolls and backup rolls when water spray causes pitting on tool steel deposits

TYPICAL APPLICATIONS

- Caster rolls

RECOMMENDED FLUX

Lincolnweld® 801®, Lincolnweld® 802™

WELDING POSITIONS

Flat, Horizontal and Circumferential

DIAMETERS / PACKAGING

| Diameter in. (mm) | 50 lb (22.7 kg) Coil | 600 lb (272 kg) Speed-Feed® Drum |
|----------------------|-------------------------|-------------------------------------|
| 3/32 (2.4) | ED037315 | ED037314 |
| 1/8 (3.2) | ED037313 | ED037312 |

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R_c)

51-55

DEPOSIT COMPOSITION⁽¹⁾ – with Recommended Neutral Flux

| %C | %Mn | %Si | %S | %P | %Cr |
|------|-----|-----|-------|-------|------|
| 0.26 | 1.1 | 0.3 | 0.005 | 0.010 | 12.0 |

TYPICAL OPERATING PROCEDURES

| Diameter, Polarity ESO - in (mm) | Wire Feed Speed m/min (in/min) | Voltage (Volts) | Approx. Current (Amps) | Deposition Rate kg/hr (lb/hr) |
|--------------------------------------|-----------------------------------|--------------------|---------------------------|----------------------------------|
| 3/32 in. (2.4 mm), DC+ 1-1/2 (38) | 1.7 (65) | 24 | 250 | 2.6 (5.7) |
| | 2.5 (100) | 28 | 525 | 7.1 (15.7) |
| | 4.4 (175) | 31 | 450 | 7.0 (15.5) |
| 1/8 in. (3.2 mm), DC+ 1-5/8 (40) | 1.5 (60) | 26 | 360 | 4.3 (9.4) |
| | 2.5 (100) | 28 | 525 | 7.1 (15.7) |
| | 3.6 (140) | 30 | 635 | 10.0 (10.0) |

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

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

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

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.

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