

Wearshield® ME

Metal-to-Earth

Typical Applications

- ▶ Muller tires
- ▶ Bucket teeth
- ▶ Augers
- ▶ Dozer blades

Welding Positions

Flat & Horizontal

Key Features

- ▶ High alloy produces chrome carbides and austenite
- ▶ Provides greater abrasion resistance than Wearshield® ABR or Wearshield® 44
- ▶ Low dilution weld metal provides eutectic mix of chromium carbides and austenite, with limited primary carbides.
- ▶ To be used on carbon and low alloy, austenitic manganese and austenitic stainless steels

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	10 lb (4.5 kg) Carton 40 lb (18.1 kg) Master Carton
1/8 (3.2)	14 (350)	ED023323
5/32 (4.0)	14 (350)	ED023324
3/16 (4.8)	14 (350)	ED023325

MECHANICAL PROPERTIES⁽¹⁾

1 Layer	Rockwell Hardness (R _c)		
	2 Layers	3 Layers	
49	59	59	

DEPOSIT COMPOSITION⁽¹⁾

On Carbon Steel	%C	%Mn	%Si	%Cr
1 Layer	2.5	0.17	0.8	27.0
2 Layers	3.0	0.17	1.0	30.5
3 Layers	3.3	0.16	1.1	32.6

TYPICAL OPERATING PROCEDURES

Polarity ⁽²⁾	Current (Amps)		
	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
DC+	125 - 175	175 - 250	220 - 330
AC	130 - 170	180 - 220	230 - 270

NOTE: Wearshield® ME is a heavily coated electrode which forms a deep cup that permits light dragging of the stick during welding. Deposits generally check crack except for single layers on thin base metal. Stringer beads produce a consistent crack spacing of about 13-25 mm (1/2-1 in).

Wide weaves may produce very widely spaced check cracks which can lead to deposit spalling in multiple layers. Weaving is not recommended. For maximum spalling resistance on carbon and low alloy steels, especially in multiple layers, apply a butter layer of Wearshield® 15CrMn, Lincore® 15CrMn or an austenitic stainless steel electrode such as Blue Max® 309/309L AC-DC, before applying Wearshield® ME.

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. ⁽²⁾ Preferred polarity is listed first.

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.

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