

LINCORE® 70-G

Severe Abrasion

KEY FEATURES

- Exceptional wear resistance with deposits that last approximately 2-3 times longer than most chrome carbide and complex carbide alloys, especially in wet abrasion applications
- Maintains high hardness after exposure to elevated temperatures up to 1000°F (538°C)
- Running this wire as a GMAW-C wire with the recommended shielding gas will reduce fume compared to open arc (FCAW-S) applications
- Best suited for carbon and low alloy steels. Not compatible for austenitic stainless or austenitic manganese steels). Limited to a maximum of two layers
- Great for high value applications where downtime is costly or replacement parts are expensive

WELDING POSITIONS

Flat & Horizontal Only

TYPICAL APPLICATIONS

- Wearplate
- Crusher Rolls
- Ore Chutes
- Screw Augers

SHIELDING GAS

75% Ar / 25% CO₂
Argon Blends

DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Spool	33 lb (15 kg) Spool	55 lb (25 kg) Coil
0.045 (1.1)	ED037243	ED037244	-
1/16 (1.6)	ED037245	ED037246	-
5/64 (2.0)	-	ED037247	-
7/64 (2.8)	-	-	ED037248

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R _c)	Wear Resistance (ASTM G65-04 Procedure A)
67-70	0.13 g mass loss

DEPOSIT COMPOSITION⁽¹⁾

% Fe	% C	% Cr	% B	% Nb	% Al	% Mn	% Si
Balance	<3	<18	<6	<10	<5	<2	<2

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

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 SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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.

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.