

Lincore® 40-S

Key Features

- Designed for rebuilding heavy equipment undercarriages
- Deposit is machinable, hot forgeable, resists rolling and sliding metal-to-metal wear
- Use on carbon and low alloy steels for good puddle control on roundabout welding
- Limited to 4 layers

Typical Applications

- Idlers
- Drive sprockets
- Mine car wheels

Conformances

AS/NZS 2576: 1140 B1*
(nearest equivalent)

Recommended Flux

- Lincolnweld® 802, 880

Diameter / Packaging

Diameter mm	Part Number	Packaging
3.2	ED015892	Coil 22.7kg

Mechanical Properties

Rockwell – HRC	
3 or more layers	39 - 42

Deposit Composition

	%C	%Mn	%Si	%Cr	%Mo
With Recommended Neutral Flux	0.12	2.75	0.50	3.3	0.85

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
3.2 mm, DC+, 32 mm	65	27	330	4.4
	90	28	425	5.9
	120	29	525	7.8
3.2 mm, DC+, 65 mm	80	29	345	5.2
	110	30	425	7.3
	145	31	500	9.4
3.2 mm, DC+, 90 mm	100	31	375	6.5
	130	32	435	8.6
	180	33	520	11.9