

Lincore[®] 55

Key Features

- Self-shielded open arc cored wire
- Produces a deposit which resists metal-to-metal wear and moderate abrasion
- To be used on carbon and low alloy steels
- Unlimited layers with appropriate preheat and interpass temperatures to avoid relief checking

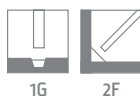
Conformances

AS/NZS 2576: 1855 B7*
(nearest equivalent)

Typical Applications

- Crane wheels
- Blower blades
- Rail ends
- Skip guides
- Cams and transfer tables

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.6	ED031121	Steel Spool 11.3kg
	ED011277	Coil 6.4kg – Master Carton 25.4kg
2.0	ED031122	Steel Spool 11.3kg
	ED011278	Coil 22.7kg
2.8	ED011280	Coil 22.7kg

Mechanical Properties

	Rockwell - HRC	
	1 Layer	2 Layers
As welded	50-59	50-60
Work hardened	53-62	56-62

Deposit Composition

	%C	%Mn	%Si	%Al	%Cr	%Mo
2.0 mm	0.45	1.3	0.53	1.4	5.3	0.80
2.8 mm	0.45	1.4	0.60	1.4	5.3	0.80

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
2.0 mm, DC+, 45 mm	125	24	190	3.2
	200	27	295	5.0
	250	30	330	6.2
2.8 mm, DC+, 64 mm	90	25	280	3.8
	125	27	350	5.2
	175	30	420	7.3

NOTE: Area to be overlaid should be clean and free of rust, oil, etc. Any previous hardfacing deposit that has been embrittled by severe work hardening should be removed. Cracks and other irregularities should be properly repaired. Cold parts should be warmed to at least 25°C. Higher preheat of 150-260°C may be necessary on thick parts or heavy sections. Interpass temperatures between 150°C and 200°C do not affect the hardness of Lincore 55 significantly.