

Lincore® 50 (continued)

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.2 mm, DC+, 25 mm	200	19-21	120	1.9
	400	23-25	190	3.9
	600	27-29	250	5.8
1.6 mm, DC+, 25 mm	150	22-24	175	2.7
	350	29-31	325	6.2
	450	32-34	365	7.9
2.8 mm, DC+, 32 mm	80	26	315	3.9
	100	27	375	4.9
	130	29	450	6.4
2.8 mm, DC+, 64 mm	100	27	315	4.9
	130	29	370	6.4
	175	31	450	8.6