

Lincore® 50

Key Features

- Self-shielded open arc cored wire
- Delivers an abrasion resistant deposit, even under conditions of moderate impact
- Larger wire diameter sizes may be used for the submerged arc process
- Can be used on low carbon, medium carbon, low alloy, manganese and stainless steels
- Limited to 4 layers

Typical Applications

- Crusher rolls
- Dredge cutter teeth
- Ore chute baffles
- Muller plows and tires
- Coal mining cutting teeth

Conformances

AS/NZS 2576: 2150 B7*
(nearest equivalent)⁷

Welding Positions



Diameter / Packaging

| Diameter mm | Part Number | Packaging |
|-------------|-------------|----------------------|
| 1.1 | ED031123 | Plastic Spool 11.3kg |
| 1.6 | ED031124 | Plastic Spool 11.3kg |
| 2.8 | ED011275 | Coil 22.7kg |

Mechanical Properties

| | Rockwell - HRc | | |
|---------------------|----------------|----------|----------|
| | 1 Layer | 2 Layers | 3 Layers |
| Mild Steel | 34-37 | 44-48 | 48-52 |
| 0.50% Carbon Steel | 41-43 | 47-50 | 50-53 |
| Austenitic Mn Steel | - | 43-45 | 48-50 |

Deposit Composition

| | %C | %Mn | %Si | %Al | %Cr | %Mo |
|-----------------|-----|-----|-----|-----|------|-----|
| Open Arc 1.2 mm | 2.4 | 1.3 | 1.0 | 0.6 | 11.4 | - |
| Open Arc 1.6 mm | 2.4 | 1.3 | 1.0 | 0.6 | 11.4 | - |
| Open Arc 2.8 mm | 2.0 | 0.9 | 1.0 | 0.6 | 9.2 | 0.5 |