

Lincore® 60-G

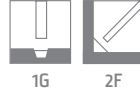
Key Features

- Gas shielded metal cored wire
- Deposit features higher alloy levels to resist both abrasion and moderate impact
- Used on carbon, low alloy, manganese and stainless steels, and cast iron
- Deposit thickness limited to two or three layers and will show some relief checking
- Can be used at temperatures up to 700°C

Typical Applications

- Augers
- Bucket lips and sides
- Loaders
- Brushing and grinding equipment
- Shaper sides and blades

Welding Positions



Shielding Gas

- 75-85% Argon / 15-25% CO₂
- 98% Argon / 2% O₂

Conformances

AS/NZS 2576: 2355 B5*
(nearest equivalent)

Diameter / Packaging

Diameter mm	Part Number	Packaging
1.1	ED029936	Plastic Spool 11.3kg

Mechanical Properties

Rockwell - HRc	
1 Layer	2 Layers
58	60

Deposit Composition

On Carbon Steel	%C	%Mn	%Si	%Cr
1 Layer	4.6	1.2	0.5	13.8
2 Layers	5.5	1.3	0.6	17.3

Typical Operating Procedures

Diameter, Polarity, ESO, Shielding Gas	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.1 mm, DC+, 20 mm	200	23-24	165	2.0
	300	25-26	225	3.0
	400	27-28	290	4.2