

LINCORE® 65 PLUS

Severe Abrasion

KEY FEATURES

- Can be used for overlays on castings
- Austenitic matrix with uniformly distributed chromium carbides
- One to four layers with proper preheat and interpass temperatures
- Improved wear resistance compared to conventional chromium carbide products

TYPICAL APPLICATIONS

- Cement
- Coal Pulverizing
- Cladding
- Wear plates
- Sugar mills
- Blades
- Dredge cutter teeth

WELDING POSITIONS

Flat & Horizontal

DIAMETERS / PACKAGING

Diameter in (mm)	50 lb (22.7kg) Coil	600 lb (272 kg) drum
1/8 (3.2)	ED037675	ED037674
7/64 (2.8)	ED037673	ED037672

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R _c)
58-65

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Cr	%Mn	%Si	%B	%Mo	%Ti	%ZR
4 layers	4.6	27	1.5	0.6	0.4	0.9	0.3	0.3

TYPICAL OPERATING PROCEDURES

Diameter, Polarity ESO - in (mm)	Wire Feed Speed m/min (ipm)	Voltage (Volts)	Approx. Current (Amps)	Deposition rate kg/hr (lb/hr)
7/64 in (2.8 mm), DC+ 1-1/8 (30)	2.5 (100)	28	280	4.4 (9.6)
	5.1 (200)	31	420	8.9 (19.7)
	7.6 (300)	33	500	13.5 (29.8)
1/8 in (3.2 mm), DC+ 1 1/2 (38) FCAW-S	2.5 (100)	27	375	6.4 (14.0)
	4.4 (175)	29	500	11.4 (25.1)
	6.7 (265)	31	625	16.7 (36.7)

⁽¹⁾ Composition and properties depend upon dilution. Single layer deposit properties depend upon base metal and/or build-up material.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume. BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment, or to provide engineering advice in relation to a specific situation. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the definition of specifications, and the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.