

Lincore® 60-0

Key Features

- Open arc self-shielded cored wire
- Primary carbide weld deposit to resist both abrasion and moderate impact
- To be used on carbon, low alloy, manganese, stainless steels and cast iron
- Deposit is limited to two layers

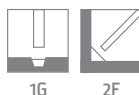
Typical Applications

- Bucket and shovel lips
- Crusher rolls and hammers
- Ore chutes
- Dozer blades
- Ripper teeth

Conformances

AS/NZS 2576: 2355 B7*
(nearest equivalent)

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.1	ED031131	Plastic Spool 11.3kg
1.6	ED031132	Plastic Spool 11.3kg
2.0	ED019887	Coil 22.7kg

Mechanical Properties

Rockwell - HRc
55-60

Deposit Composition

	%C	%Mn	%Si	%Al	%Cr
2 Layers – Open Arc	3.7-4.3	0.8-0.9	0.8-1.0	0.3-0.4	20.0-21.3

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.1 mm, DC+, 25 mm	200	21	125	1.9
	400	25	185	3.7
	500	27	210	4.7
1.6 mm, DC+, 25 mm	200	28	240	3.4
	300	31	300	5.1
	450	33	350	7.5
2.0 mm, DC+, 32 mm	125	26	250	3.4
	200	30	350	5.4
	250	32	400	6.9

NOTE: Deposit thickness limit is two layers unless high travel speed is used to obtain very closely spaced check cracks. Many layers can be used with high travel speed and small bead sizes to ensure close-spaced check cracks. Lincore® 60-0 deposit cross cracks (commonly called relief-checking) on cooling. This is desirable, since cross-cracking of the deposit relieves cooling stresses and prevents spalling.