

Lincore® 55-G

Key Features

- Gas shielded metal cored wire
- Produces a deposit which resists metal-to-metal wear and moderate abrasion
- To be used on carbon and low alloy steels
- Unlimited layers with appropriate preheat and interpass temperatures to avoid relief checking

Typical Applications

- Crane wheels
- Blower blades
- Bucket lips
- Dredge parts
- Tillage tools

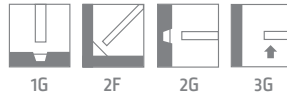
Conformances

AS/NZS 2576: 1855 B5*
(nearest equivalent)

Shielding Gas

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

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.1	ED028176	Plastic Spool 11.3kg
1.6	ED028177	Plastic Spool 11.3kg

Mechanical Properties

Shielding Gas	Rockwell - HRc		
	1 Layer	2 Layers	4 Layers
75%Ar/25%CO ₂	50-51	53-54	54-55
98%Ar/2%O ₂	54-55	55-56	56-57

Deposit Composition

On Carbon Steel [2 Layers]	%C	%Mn	%Si	%Cr	%Mo
1.1 mm – 75%Ar/25%CO ₂	0.39	1.24	0.93	5.6	0.55
1.1 mm – 98%Ar/2%O ₂	0.47	1.30	1.18	6.4	0.65
1.6 mm – 75%Ar/25%CO ₂	0.41	1.24	0.95	5.7	0.57
1.6 mm – 98%Ar/2%O ₂	0.45	1.25	1.10	5.8	0.58