

Lincore® 30-S

Key Features

- Intended for build-up before final overlay, and as a final surface for metal-to-metal wear with moderate impact
- For automatic and semi-automatic operation on mild and low alloy steels
- Good resistance to cross checking
- Unlimited deposit thickness with proper preheat and interpass temperatures and procedures

Typical Applications

- | | |
|---------------------|-----------------------|
| For Build-up | For Hardfacing |
| • Tractor rollers | • Shafts |
| • Idlers | • Track rails |
| • Trunnions | • Idlers |
| • Crane wheels | |

Conformances

AS/NZS 2576: 1125 B1*
(nearest equivalent)

Recommended Flux

- Lincolnweld® 802, 860

Diameter / Packaging

Diameter mm	Part Number	Packaging
2.4	ED011200	Coil 22.7kg
3.2	ED015889	Coil 22.7kg
	ED015891	Speed-Feed Drum 272kg

Mechanical Properties

Rockwell – HRc	
6 Layers - Under 802 Flux	6 Layers - Under 860 Flux
27	27

Deposit Composition

On Carbon Steel	%C	%Mn	%Si	%Cr
6 Layers - Under 802	0.11	2.5	0.40	0.50
6 Layers - Under 860	0.11	2.7	0.60	0.50

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
2.4 mm, DC+, 38 mm	60	26	220	2.7
	120	27	360	5.2
	180	28	500	7.7
3.2 mm, DC+, 40 mm	50	27	310	3.4
	80	28	450	6.4
	110	28	600	9.1