

# Lincore® 35-S

## Key Features

- Intended for rolling and sliding metal-to-metal wear with moderate impact and abrasion
- For automatic and semiautomatic operation on mild and low alloy steels
- Recommended as final overlay where medium hardness and good machinability are required
- Unlimited deposit thickness with proper preheat and interpass temperatures and procedures

## Typical Applications

### For Build-up

- Tractor rollers
- Idlers
- Trunnions
- Crane wheels
- Caster rolls

### For Hardfacing

- Shafts
- Track rails
- Idlers
- Mine car wheels

## Conformances

**AS/NZS 2576:** 1135 B1\*  
(nearest equivalent)

## Recommended Flux

- Lincolnweld® 802, 880

## Diameter / Packaging

Diameter mm	Part Number	Packaging
3.2	ED019881	Coil 22.7kg

## Mechanical Properties

Rockwell – HRC	
3 Layers	35 - 39

## Deposit Composition

On Carbon Steel	%C	%Mn	%Si	%Cr	%Mo
With Recommended Neutral Flux	0.19	1.7	0.60	2.0	0.50

## Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
3.2 mm, DC+, 40 mm	50	28	340	3.6
	100	28	500	7.5
	150	28	660	11.3