

Lincore® 60-0

GENERAL DESCRIPTION

Lincore 60-0 is a self shielded, open arc, flux cored tubular electrode that produces a primary carbide weld deposit. Although, designed primarily for the open arc process it can be used with a neutral flux to improve the weld shape, minimise fume and remove arc glare.

WELDING POSITIONS



ISO/ASME PA/1G

CURRENT TYPE

DC+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Al
4.2	1.6	1.3	25.4	0.6

STRUCTURE

In the as welded condition the microstructure consists of primary carbides in an austenite - carbide eutectic matrix

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical hardness values

Layer 1	55 - 60 HRc
Layer 2	58 - 60 HRc
Welded on Mild Steel Plate (12mm)	

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.1	1.6	2.0
Unit : 11.34 kg coil 22RR	X	X	X

Lincore® 60-0: rev. EN 22

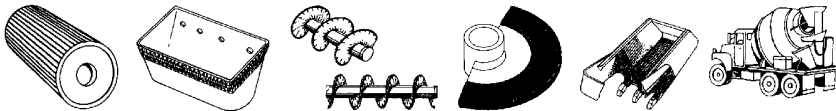
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APPLICATION

Lincore 60-O produces an primary carbide weld deposit with a hardness range of 55-60HRc. The primary carbide microstructure makes Lincore 60-O ideally suitable for APLs of severe abrasion. Typical APLs include:

Typical applications include:

- Crusher rolls, plates and jaws
- Conveyor screws and sleeves
- Bucket and shovel lips
- Brick & coke machinery
- Cement mill parts



ADDITIONAL INFORMATION

When welding with Lincore 60-O stringer beads should be employed. Weaving is not advised since wide weaves generally increase the check crack spacing which can result in deposit spalling. Preheat is not necessary when surfacing austenitic substrates such as stainless steels and manganese steels, although the interpass temperature should be limited to about 260°C for manganese steels. For low alloy and high carbon steels a preheat of 200°C is necessary to prevent heat affected zone cracking.

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The weld metal is not machinable or forgeable and it readily check cracks. The deposit thickness is usually limited to 2 layers, as excessive build-up will result in chipping and fragmentation.

For applications requiring build-ups in excess of 2 layers, buttering layers of Lincore 33, Wearshield BU30 or RepTec 126 Alternatively, a preheat of 650°C can be used to eliminate the formation of check cracks

CALCULATION DATA

Diameter (mm)	Wire Feed	Current (A)	Arc Voltage (V)	Deposition rate (kg/h)
	Speed (cm/min)			
1.1	5.1 to 12.7	125-210	21-27	1.9-4.7
1.6	5.1 to 11.4	240-350	28-33	3.4-7.5
2.0	3.2 to 6.4	250-400	25-32	3.4-6.9

COMPLEMENTARY PRODUCTS

Complementary products include Wearshield® 60.