

LINCORE® 65-0

Severe Abrasion

KEY FEATURES

- Deposits include higher carbon and chrome levels than Lincore® 60-0
- Recommended for use on wear plate, coal pulverizer rolls, earth engaging tools, and on slurry pipe and elbows
- To be used on carbon, low alloy, manganese, stainless steels and cast iron
- Limited to four layers

TYPICAL APPLICATIONS

- Screw augers
- Ore chutes and wearplates
- Crusher rolls
- Ripper teeth

WELDING POSITIONS

Flat & Horizontal

DIAMETERS / PACKAGING

Diameter in (mm)	50 lb (22.7 kg) Coil	500 lb (227 kg) Speed-Feed® Drum
1/8 (3.2)	ED026076	ED026082
7/64 (2.8)	ED026077	ED026083

MECHANICAL PROPERTIES⁽¹⁾

Rockwell Hardness (R _c)		
1 Layer	2 Layers	4 Layers
57	60	64

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%Cr
1 Layer	3.7	1.3	0.7	19.9
2 Layers	4.9	1.6	1.0	26.2
4 Layers	5.7	1.8	1.1	30.8

TYPICAL OPERATING PROCEDURES

Diameter, Polarity ESO - in (mm)	Wire Feed Speed m/min (in/min)	Voltage (Volts)	Approx. Current (Amps)	Deposition Rate kg/hr (lb/hr)
7/64 in (2.8 mm), DC+ 1-1/8 (30)	2.5 (100)	28	280	4.4 (9.6)
	5.1 (200)	31	420	8.9 (19.7)
	7.6 (300)	33	500	13.5 (29.8)
1/8 in (3.2 mm), DC+ 1-1/2 (37)	2.5 (100)	27	375	6.4 (14.0)
	4.4 (175)	29	500	11.4 (25.1)
	6.7 (265)	31	625	16.7 (36.7)

4 layers of Lincore 65-0	
Condition	Rockwell Hardness C
As-Welded	63
Aged at 1200°F (650°C) for 2 hours	56
Aged at 1400°F (760°C) for 2 hours	54

⁽¹⁾ Composition and properties depend upon dilution. Single layer deposit properties depend upon base metal and/or build-up material.

NOTE: Postweld heat treatment up to 1400°F (760°C) will not affect abrasion resistance very significantly, but will affect hardness to some extent. Typical results are shown above:

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.