

Hardfacing cored wire

Classification

DIN 8555 : MF6-GF-55-CGR

General description

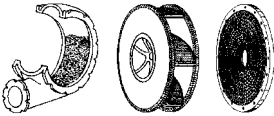
Lincore 420 is a self shielded, open arc, flux cored tubular electrode that produces a martensitic deposit similar to AISI 420 stainless steel. The arc characteristics are excellent producing minimal spatter and good slag removal.

Application

Lincore 420 is martensitic stainless hardfacing electrode designed to provide overlay deposits that resists metal wear under corrosion.

Typical applications include:

- Sand pumps
- Dredging equipment
- Fans
- Valve seats in steam and liquid pipes



Mechanical properties, typical, all weld metal

	Typical hardness values
Layer 1	52 HRc
Layer 2	51 HRc
Layer 3	53 HRc
Welded on Mild Steel Plate (12mm)	

Packaging and available sizes

Unit type	Diameter (mm)			
	1.6	2.4	3.2	4.0
14 kg spool S300	X			
22.68 kg coil 50C		X	X	
272.2 kg speed-feed® drum			X	X

Lincore® 420: rev. EN 21

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

Additional information

All work-hardened base material and previously deposited material should be removed prior to applying a new deposit, since such areas are prone to embrittlement and possible cracking.

Areas that contain irregularities such as cracks and deep gouges can be repaired locally using Wearshield[®] BU30 or Wearshield[®] 15CrMn prior to hardfacing with Lincore 420.

Preheat would be needed if the welding is done over either highly restrained material or martensitic stainless base metal.

A preheat and interpass temperature in the range of 200-300°C can be used depending on the nature of the material to be welded.

Under conditions of low dilution, the microstructure is similar to that of AISI 420 martensitic stainless steel. This structure provides good abrasion resistance under conditions of severe corrosion and high impact. At higher dilutions, when overlaid on mild steel or low alloy steel, the weld metal microstructure will retain its martensitic stainless structure. But the reduced chromium level might adversely affect the corrosion resistance of the deposit.

Welding positions



ISO/ASME PA/1G

Current type

DC +

Chemical composition (w%), typical, all weld metal

ø1.6 mm	C	Mn	Si	Cr	ø2.0 mm	C	Mn	Si	Cr
	0.5	1.7	0.9	11		0.5	1.4	0.7	11

Structure

Martensitic + ferritic

Calculation Data

Diameter (mm)	Wire Feed Speed (m/min)	Current (A)	Arc Voltage (volts)	Deposition Rate (kg/h)
1.1	5.1 to 15.2	120 - 250	20 - 28	1.9 - 5.8
1.6	3.8 to 8.9	175 - 365	23 - 33	2.7 - 7.9
2.0	3.2 to 6.4	210 - 380	27 - 23	3.4 - 6.8

Complementary products

Complementary products include Wearshield[®] 420