

MMAW (Stick)

Lincoln Electric's range of manual metal arc welding (MMAW) electrodes will conveniently meet your welding needs. From structural purpose to special purpose, all are backed by Lincoln Electric's long history of manufacturing quality electrodes. Lincoln electrodes continue to be the 'electrode of choice' throughout the welding industry. Also available in a variety of packaging.

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GTAW (TIG)

Lincoln Electric® gas tungsten arc welding (GTAW) cut length filler consumables provide:

- excellent welding characteristics
- precise control of wire chemistry
- minimisation of contamination on the wire surface

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GMAW (MIG)

Lincoln Electric® gas metal arc welding (GMAW) wires have earned their reputation for being high quality MIG wires in the Australian industry. They provide:

- excellent arc characteristics
- a reliable source of supply
- better wire feeding
- superior quality control

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FCAW (Flux Cored)

Outershield® flux-cored arc welding (FCAW) wires are designed for use with either 100% CO₂ and/or Argon blend mixed shielding gases. The deep penetrating characteristics of these electrodes make them ideal for welding of fillet, lap and butt welds in both single and multi-pass welding applications. Outershield® wires provide:

- excellent operator appeal
- exceptional alloy control
- good resistance to porosity
- high deposition rates and efficiencies

Innershield® flux-cored arc welding (FCAW) wires are especially suited to outdoor or drafty locations. No external shielding gas or flux is required, making the entire Innershield® process very user friendly. Innershield® wires provide:

- open arc process - no gas shielding required
- welding outdoors or drafty locations
- capabilities to operate in all positions
- simple wire feeding equipment

Outershield®
Innershield®
Stainless Steel

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Hardfacing

Lincoln Electric® has a range of maintenance and repair consumables that offer resistance to metal-to-metal, abrasion, impact or a combination of these types of wear. Lincoln Electric® consumables are well supported by internationally recognised technical expertise.

Build-Up
Metal-to-Metal Wear
Abrasive Wear
Impact Loading & Abrasive Wear
Metal-to-metal & Corrosion
Special Purpose
Fluxes

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CONSUMABLES INDEX
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SAW (Sub-arc)

Lincoln Electric[®] is the industry leader in submerged arc welding (SAW) equipment and consumables. Our wires (solid and flux-cored) and fluxes offer:

- exceptional weld quality and bead appearance
- flexibility for both semi-automatic and automatic welding
- excellent welding characteristics in single and multi-pass welds in the flat and horizontal positions

Carbon & Low Alloy Steel (Solid wire)

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Low Alloy Steel (Cored Wire)

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Stainless Steel (Solid Wire)

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Fluxes

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Welding Technology Centre

Lincoln Electric's Technical Sales Representatives will be able to assist you with most of your welding consumable issues. The additional technical assistance, uniquely provided by our Welding Technology Centre is available to Lincoln Electric[®] customers, ensuring that when you buy Lincoln Electric[®], you are not alone. These additional services include, but are not limited to, material analysis and identification, failure analysis, welding procedure recommendation, welding procedure qualification and mechanical testing.

For further information, contact Lincoln Electric[®] in Australia on 1300 LINCOLN (1300 546 265) or New Zealand on 0800 728 720.

MMAW (Stick)

Consumables

Lincoln Electric's range of MMAW electrodes will conveniently meet your welding needs. Our high quality, structural purpose and specialised electrodes are backed by Lincoln Electric's long history of manufacturing electrodes. Lincoln Electric® electrodes continue to be the 'electrode of choice' throughout the welding industry.

General Purpose

Pantafix®

Classification: AS 1553.1: E4113-0*
ISO 2560-B-E4313-G A
AWS A5.1: E6013

For general purpose, fantastic performance on thin plates, great ability at bridging wide gaps on thinner sections. Good arc start and restart behavior. Weldable with OCV transformers (min. OCV 42). Good X-ray soundness.

Supra™

Classification: AS 1553.1: E4112-0*
ISO 2560-B-E4312-G A
AWS A5.1: E6012

Ideal for shipbuilding repairs. Well suited for welding on primed or rust covered steel. Recommended for bridging wide gaps, weldable in all positions with one current setting.

EasyArc™ Supa 13

Classification: AS/NZS 4855-B E4313 A;
AWS A5.1 E6013

All-positional, rutile-type electrode for touch-welding or where best appearance is required. Used for all general fabrication work where good mechanical properties are necessary.

Iron Powder

Ferrod™ 120T

Classification: AS 1553.1: E4824-0*
ISO 2560-B-E4924 A
AWS A5.1: E7024

The easy to use general purpose Iron Powder electrode, high current can be used with low spatter. Adjustable run-out length to optimise fillet size. Excellent side wall wetting. Self releasing slag.

* Superseded by new ISO standard

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.5	571714	350	2.80PK	14.00CT	924
3.2	571752	350	4.80PK	14.40CT	950.4
4.0	571769	350	5.40PK	16.20CT	1069.2

2.5	504842	350	2.80PK	14.00CT	980
2.0	504859	350	5.00PK	15.00CT	1050
4.0	504866	350	5.00PK	15.00CT	1050

2.5	CC010201	300	5.0PK	15.00CT	1500
3.2	CC010202	350	5.0PK	15.00CT	1680

4.0	555882	450	6.20PK	18.60CT	911.4
5.0	555998	450	6.40PK	19.20CT	940.8

Low Hydrogen

Jet Weld[®] LH[®]-70

Classification: AS 1553.1: E4818-4 H5*
 ISO 2560-B-E4918 A U H5
 AWS A5.1: E7018-H4R

An electrode for welding on thick sections and restrained joints when cracking is an issue. It's also a good choice when the project involves hard-to-weld steels. Jet Weld[®] LH-70 also offers high deposition rates.

Conarc[®] 49C (SRP*)

Classification: AS 1553.1: E4818-5 H5R*
 ISO 2560-B-E4918 A U H5R
 AWS A5.1: E7018-1 H4R

A premium quality electrode for critical, out-of-position welding. It offers superior welding characteristics; clean weld puddle, uniform slag follow, and superior wash-in with no undercutting. Also great for welding on steels with marginal weldability. Moisture resistant coating.

Conarc[®] 51 (SRP*)

Classification: AS 1553.1: E4816-4 H5R*
 ISO 2560-B-E4916 A U H5R
 AWS A5.1: E7016-1 H4R

A basic type, low hydrogen electrode with excellent impact properties. In sizes of 2.5mm and 3.2mm this electrode is exceptional for root pass welding. Moisture resistant coating.

Conarc[®] V250

Classification: AS 1553.1: E4828*
 ISO 2560-B-E4928 A
 AWS A5.1: E7028

Deposition rate may be compared with submerged arc welding. Easy slag release. Reliable impact toughness -40°C, good CTOD at -10°C. Excellent X-ray quality.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.4	ED010568	356	22.68EO	-	1361
3.2	ED010561	356	22.68EO	-	1361
4.0	ED010575	356	22.68EO	-	1361
4.8	KC704825	356	25.00HC	-	900
4.8	ED010564	356	22.68EO	-	1361

2.5	511420	350	1.40SRP	14.00CT	672
3.2	511437	350	2.00SRP	16.00CT	768
4.0	511505	350	1.60SRP	12.80CT	614.4
3.2	509243	350	4.40PK	13.20CT	924
4.0	509359	350	4.70PK	14.10CT	987

2.5	511567	350	1.40SRP	14.00CT	672
3.2	511581	350	1.80SRP	14.00CT	691.2
4.0	511611	350	1.40SRP	11.20CT	537.6
3.2	509823	350	4.70PK	13.20CT	987
4.0	509847	350	4.60PK	13.20CT	966

4.0	555125	450	5.90PK	17.70CT	-
5.0	555132	450	5.80PK	17.40CT	-
6.0	555156	450	5.80PK	17.40CT	-

MMAW (Stick)

Consumables

Low Alloy (hydrogen controlled)

SL22G (SRP*)

Classification: AS 1553.2: E5518-B1 H5*
ISO 3580-B-E5518-CM H5
AWS A5.5: E8018-B1 H4

For welding creep resistant Cr-Mo-V type steels that have a maximum service temperature up to 550°C. A basic, all-position, low hydrogen electrode with 115-120% recovery. DC welding preferred. Moisture resistant coating.

SL19G (SRP*)

Classification: AS 1553.2: E5518-B2 H5*
ISO 3580-B-E5518-1CM H5
AWS A5.5: E8018-B2 H4

Produces a nominal 1.25Cr-1Mo weld deposit for use with creep and hydrogen resistant Cr-Mo steels. Maximum service temperature of 550°C. Also a good choice for use on many weathering steels. DC welding preferred. Moisture resistant coating.

SL20G (SRP*)

Classification: AS 1553.2: E6218-B3 H5*
ISO 3580-B-E6218-2C1M H5
AWS A5.5: E9018-B3 H4

Used for welding 2.25Cr-1Mo steels commonly used in the power and petrochemical industries. Maximum service temperature of 600°C. Basic, low hydrogen electrode with 115-120% recovery. Good mechanical properties in the as-welded and stress relieved condition. Moisture resistant coating.

SL9Cr (P91) (SRP*)

Classification: AS 1553.2: E6216-B9 H5*
ISO 3580-B-E6216-9C1MV H5
AWS A5.5: E9016-B9 H4

Specialised electrode developed for the power and petrochemical industry. Used for welding 9Cr-1Mo type steels with maximum service temperature of 650°C. Moisture resistant coating.

Conarc® 80

Classification: AS 1553.2: E7618-M*
ISO 3580-B-E7618-G
AWS A5.5: E11018M

Suitable for welding high strength steel grades when both under matching and matching strength is required (UTS up to 800 N/mm²). Typical steels would be Bisalloy 60, 70 or 80. Good impact values at -50°C.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.5	524246	350	1.40SRP	14.00CT	-
3.2	524284	350	2.00SRP	16.00CT	-
4.0	524277	350	1.50SRP	12.00CT	-

2.5	524062	350	1.40SRP	14.00CT	-
3.2	524109	350	2.00SRP	16.00CT	-
4.0	524093	350	1.50SRP	12.00CT	-

2.5	524154	350	1.40SRP	14.00CT	-
3.2	524192	350	2.00SRP	16.00CT	-
4.0	524185	350	1.50SRP	12.00CT	-

2.5	525700	350	1.40SRP	14.00CT	-
3.2	525724	350	1.80SRP	14.40CT	-
4.0	525731	350	1.50SRP	12.00CT	-

3.2	523850	350	4.50PK	13.50CT	-
4.0	523867	350	5.00PK	15.00CT	-

- * SRP – Sahara ReadyPack® & EMR-Sahara (basic) electrodes.
- EMR-Sahara covered electrodes are designed to be low in moisture and show a very low moisture absorption/pick-up.
- Electrodes can be consumed from an opened SRP within 12 hours and still return a diffusible hydrogen level of <5ml/100g.
- SRP, moisture resistant vacuum packaging, are convenient and easily carried to the welding job site
- Content of one or two packages is usually good for one working day.
- Cost saving: no maintenance of quivers, no quality control on redrying procedures, no loss of time during transportation of electrodes to the job site.
- Millions of the well known Sahara ReadyPack® have been consumed in shipbuilding, chemical industry and in offshore projects.

Cellulose

Fleetweld[®] 5P

Classification: AS1553.1 E4110-2*
 ISO 2560-B-E4310 A
 AWS A5.1: E6010

A great choice for pipe root runs and also for welding on dirty, rusty, greasy or painted steel – especially in vertical or overhead applications. This versatile, fast freeze electrode offers excellent arc stability. A long-time favourite among operators who handle cross-country and in-plant pipe welding.

Fleetweld[®] 5P+

Classification: AS1553.2 E5510-G*
 ISO 3850-B-E5510-G
 AWS A5.5: E8010-G

A similar electrode to the traditional Fleetweld[®] 5P, plus easier striking, easier slag removal and improved final appearance. It's a first choice for pipe welding, and vertical-up and overhead plate welding.

Shield-Arc[®] HYP+

Classification: AS1553.2 E4810-P1*
 ISO 3850-B-E4810-G
 AWS A5.5: E7010-P1

The tendency for “fingernailing” and arc stick will be virtually eliminated through the use of Shield-Arc[®] HYP+. Designed for all passes of API 5L X-52 through X-65 high strength pipe. Provides the welder with a clean, visible weld puddle and superior puddle control. A true E4810-P1 type electrode.

Shield-Arc[®] 70+

Classification: EAS1553.2 E5510-G*
 ISO 3850-B-E5510-G
 AWS A5.5: E8010-G

Shield-Arc[®] 70+ is an outstanding choice for welding API 5L X-56 through X-70 grade pipe, as well as for a wide range of sheet metal welding jobs. It is particularly well suited to high silicon (up to 30%Si) pipe applications. Low temperature impact properties are excellent.

Pipeliner[®] 8P+

Classification: AS1553.2 E5510-P1*
 ISO 3850-B-E5510-G
 AWS A5.5: E8010-P1

High deposition rate, metal cored wire with less smoke, spatter and slag (virtually none) than comparable wires. If high welding speed/high productivity are the priority, MC-710 will easily weld as fast as you can. A smart economic choice for high productivity, high volume fabrication and production welding. Will suit robotic applications. Recommended shielding – 5-25%CO₂ in Argon.

Pipeliner[®] 6P+

Classification: AS1553.1 E4110-2*
 ISO 2560-B-E4310-A
 AWS A5.5: E6010

Pipeliner[®] 6P+ is an all-position cellulosic pipe electrode designed especially for vertical down root pass welding. This electrode is based on a long-time favorite among cross-country pipeline welders.

N.B: Pipeliner[®] electrodes are manufactured under lot control. A certificate of test showing actual deposit chemistry and mechanical properties as per AWS is available with every lot of electrode.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.4	ED010211	305	22.68EO	-	1361
3.2	ED010203	356	22.68EO	-	1361
4.0	ED010216	356	22.68EO	-	1361
4.8	ED010207	356	22.68EO	-	1361

2.4	ED010283	305	22.68EO	-	1361
3.2	ED010278	356	22.68EO	-	1361
4.0	ED010285	356	22.68EO	-	1361
4.8	ED010281	356	22.68EO	-	1361

3.2	ED029511	356	22.68EO	-	1361
4.0	ED029513	356	22.68EO	-	1361
4.8	ED029509	356	22.68EO	-	1361

3.2	ED012841	356	22.68EO	-	1361
4.0	ED012849	356	22.68EO	-	1361
4.8	ED012845	356	22.68EO	-	1361

3.2	ED030826	356	22.68EO	-	1361
4.0	ED030827	356	22.68EO	-	1361
5.0	ED030828	356	22.68EO	-	1361

3.2	ED030848	356	22.68EO	-	1361
4.0	ED030849	356	22.68EO	-	1361
5.0	ED031653	356	22.68EO	-	1361

Stainless Steel

Our range of high quality stainless steel electrodes are manufactured in Europe by Lincoln Smitweld. Lincoln Smitweld are world leaders in the development and manufacture of stainless steel and other high alloy electrodes. Their products are held in the highest regard by fabricators globally throughout a variety of industries.

Limarosta® 304L

Classification: **AS1553.3: E308L-16**
AWS A5.4: E308L-16

Designed for welding '18-8' type stainless steels such as 304/304L (wrought) and CF-3/CF-8 (cast). Deposit is highly resistant to oxidation and corrosion. Produces a mirror-like bead appearance with excellent wetting, slag release and resistance to porosity.

Arosta® 304L

Classification: **AS1553.3: E308L-16**
AWS A5.4: E308L-16

Same composition weld metal as Limarosta® 304L, with better welding characteristics in out-of-position welding.

Limarosta® 316L

Classification: **AS1553.3: E316L-16**
AWS A5.4: E316L-16

Designed for welding Mo bearing austenitic stainless steels such as 316/316L (wrought) and CF-3M/CF-8M (cast). Deposit is highly resistant to oxidation and corrosion, especially pitting corrosion. Produces a mirror-like bead appearance with excellent wetting, slag release and resistance to porosity. It should not be used for service in urea manufacture, as this environment will attack the ferrite.

Arosta® 316L

Classification: **AS1553.3: E316L-16**
AWS A5.4: E316L-16

The ideal choice for flat and horizontal groove and fillet welds where high deposition rates are important. Outershield® 70 is also appealing as it returns optimum welding performance on materials with high levels of rust, oil or mill scale. Recommended shielding – 100% CO₂.

Vertarosta® 316L

Classification: **AS1553.3: E316L-15**
AWS A5.4: E316L-15

The ideal choice for flat and horizontal groove and fillet welds where high deposition rates are important. Outershield® 70 is also appealing as it returns optimum welding performance on materials with high levels of rust, oil or mill scale. Recommended shielding – 100% CO₂.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.5	557329	350	2.70CT	8.10CT	-
3.2	557367	350	4.70CT	14.10CT	-
4.0	557398	450	5.80CT	17.40CT	-
2.5	527537	350	2.60CT	7.80CT	-
3.2	527834	350	4.80CT	14.40CT	-
4.0	527940	350	4.50CT	13.50CT	-
2.5	557442	350	2.80CT	8.40CT	-
3.2	557466	350	4.90CT	14.70CT	-
4.0	557497	450	5.90CT	17.70CT	-
2.5	529180	350	2.70CT	8.10CT	-
3.2	529487	350	4.90CT	14.70CT	-
4.0	529593	350	4.80CT	14.40CT	-
2.5	558098	300	2.70CT	8.10CT	-

Stainless Steel

Limarosta[®] 309S

Classification: AS1553.3: E309L-16
 AWS A5.4: E309L-16

Primarily for welding 309/309S (wrought) and CH-10/CH-20 (cast) base materials. A high Cr austenitic stainless steel electrode for applications where improved corrosion and oxidation resistance are required. Also used for dissimilar metals joining such as stainless steel to carbon/low alloy steel. Produces a mirror-like bead appearance with excellent wetting, slag release and resistance to porosity.

Arosta[®] 309Mo

Classification: AS1553.3: E309MoL-16
 AWS A5.4: E309MoL-16

Similar composition to Limarosta[®] 309S with the addition of Mo and with better welding characteristics in out-of-position welding. Designed for welding type 316L clad steels and for overlays on carbon steel.

Limarosta[®] 312

Classification: AS1553.3: E312-16
 AWS A5.4: E312-16

For welding 312 (wrought) and CE-30 (cast) base materials. A high Cr and Ni alloyed electrode excellent for repair welding. An alloy commonly used to join difficult to weld steels such as armour plate, austenitic manganese steels and high carbon steel. Excellent weldability and slag detachability. Often used to weld steels of unknown origin.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.5	557534	350	2.80CT	8.40CT	-
3.2	557565	350	4.90CT	14.70CT	-
4.0	557589	450	5.90CT	17.70CT	-

2.5	528633	350	2.60CT	7.80CT	-
3.2	528824	350	4.70CT	14.10CT	-
4.0	528930	350	4.80CT	14.40CT	-

2.5	557640	350	2.60CT	7.80CT	-
3.2	557664	350	5.00CT	15.00CT	-
4.0	557671	350	5.00CT	15.00CT	-

3.2	ED028116	300	0.45TB	9.07CT	-
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3.2	ED025116	350	0.45TB	9.07CT	-
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Cast Iron

Softweld[®] 55Ni

Classification: AWS A5.15: ENiFe-CI

Used for repairing spheroidal graphite (nodular) cast iron and for joining it to itself and to steel.

Softweld[®] 99Ni

Classification: AWS A5.15: ENi-CI

Used for repairing ordinary grey cast iron and for joining it to itself and to steel.

Carbon & Low Alloy Steel

Lincoln® ER70S-2

Classification: AWS A5.18: ER70S-2
AS 1167.2: R2

Triple-deoxidised rod that produces high quality welds over most surface conditions.
Recommended shielding – 100% Argon.

LNT 25

Classification: AWSA5.18: ER70S-3
AS 1167.2: R3

A low carbon, medium manganese, high silicon filler that can be used for both single and multi-pass welding. Use for applications requiring 480MPa (70,000psi) minimum tensile strength.
Recommended shielding – 100% Argon.

LNT 19

Classification: AWS A5.28: ER80S-B2
AS 1167.2: RB2

For welding creep resistant Cr-Mo steels used in elevated temperature (up to 500°C) and corrosive service environments.
Recommended shielding – 100% Argon.

LNT 20

Classification: AWS A5.28: ER90S-B3
AS 1167.2: RB3

For welding creep resistant Cr-Mo steels used in elevated temperature (up to 600°C) and corrosive service environments.
Recommended shielding – 100% Argon.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.4	ED025881	915	9.07CT (2.27TB)	-	-
3.2	ED025882	915	9.07CT (2.27TB)	-	-
2.4	604146	1000	2.00TP	-	-
3.0	604177	1000	2.00TP	-	-
3.0	580341	1000	5.00TC	-	-
2.4	582659	1000	5.00TC	-	-
2.4	604351	1000	2.00TP	-	-
3.0	604375	1000	2.00TP	-	-
2.4	605556	1000	2.00TP	-	-
3.0	605570	1000	2.00TP	-	-

Stainless Steel

Lincoln[®] 308L

Classification: AWS A5.9: ER308L
 AS 1167.2: R308L

Premium quality stainless steel cut lengths for TIG welding. Chemically balanced and manufactured for use on the appropriate stainless steel base metals. Stamped on both ends with the alloy grade for easy identification.
 Recommended shielding – 100% Argon

Lincoln[®] 316L

Classification: AWS A5.9: ER316L
 AS 1167.2: R316L

Premium quality stainless steel cut lengths for TIG welding. Chemically balanced and manufactured for use on the appropriate stainless steel base metals. Stamped on both ends with the alloy grade for easy identification.
 Recommended shielding – 100% Argon

Lincoln[®] 309L

Classification: AWS A5.9: ER309L
 AS 1167.2: R309L

Premium quality stainless steel cut lengths for TIG welding. Chemically balanced and manufactured for use on the appropriate stainless steel base metals. Stamped on both ends with the alloy grade for easy identification.
 Recommended shielding – 100% Argon

Lincoln[®] 2209

Classification: AWS A5.9: ER2209

Premium quality stainless steel cut lengths for TIG welding. Chemically balanced and manufactured for use on the appropriate stainless steel base metals. Stamped on both ends with the alloy grade for easy identification.
 Recommended shielding – 100% Argon

Aluminium

Super Glaze[®] 4043

Classification: AWS A5.10: ER4043
 AS 1167.2: R4043

Solid, cut length aluminium-silicon alloy filler for use on many weldable cast and wrought aluminium alloys.
 Recommended shielding – 100% Argon.

Super Glaze[®] 5356

Classification: AWS A5.10: ER5356
 AS 1167.2: R5356

Solid, cut length aluminium-manganese alloy filler for use on many weldable wrought aluminium alloys.
 Recommended shielding – 100% Argon.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.0	365080	915	3.00TC	-	-
1.6	365081	915	3.00TC	-	-
2.4	365082	915	3.00TC	-	-
3.2	365083	915	3.00TC	-	-

1.0	365060	915	3.00TC	-	-
1.6	365061	915	3.00TC	-	-
2.4	365062	915	3.00TC	-	-
3.2	365063	915	3.00TC	-	-

1.6	365091	915	3.00TC	-	-
2.4	365092	915	3.00TC	-	-
3.2	365093	915	3.00TC	-	-

1.6	365221	915	3.00TC	-	-
2.0	365222	915	3.00TC	-	-

2.4	ED031112	915	4.54CT	-	-
3.2	ED031113	915	4.54CT	-	-

2.4	ED031109	915	4.54CT	-	-
3.2	ED031110	915	4.54CT	-	-

Carbon & Low Alloy Steel

The Lincoln Electric® range of UltraMag™ MIG wires have earned their reputation for exceptional arc characteristics and trouble-free performance. UltraMag™ wires are extensively used across a full range of applications from home-handyman and farming through to heavy industrial fabrication, construction and mining. Other applications include welding pipe and pressure vessels.

UltraMag™ S3

Classification: AS/NZS 2717.1: ES3-GM/C-W503AH
AWS A5.18: ER70S-3

A low carbon, medium manganese, high silicon wire available only in 1.3mm (0.052") diameter. An excellent choice for single pass welding (large downhand and horizontal fillet welds) and for multi-pass welding of killed or semi-killed steels.

UltraMag™ S4

Classification: AS/NZS 2717.1: ES4-GM/C-W503AH
AWS A5.18: ER70S-4

UltraMag™ S4 offers a mid-range level of manganese and silicon – higher than UltraMag™ S3 but lower than the UltraMag™ S6. Performs well when welding on materials with a low to medium amount of dirt, rust or mill scale.

UltraMag™ S6



Classification: AS/NZS 2717.1: ES6-GM/C-W503AH
AWS A5.18: ER70S-6

UltraMag™ S6 has the highest level of manganese and silicon and can be used when welding on materials with a medium to high presence of dirt, rust or mill scale. In addition UltraMag™ S6 produces a more fluid weld pool and is an excellent choice when bead appearance is important.

EasyMIG™ S6

Classification: AS/NZS 2717.1
ES6-GM-W503AH
AWS A5.18 ER70S-6

Copper-coated, steel wire for gas metal arc welding of mild or medium tensile steel using carbon dioxide or argon-based shielding gases. Higher manganese and silicon content offer better weld metal de-oxidization, improved fillet shape, lower spatter levels and excellent operator appeal.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
13	812893	-	15.00SP	-	1080

0.9	C09P015P4	-	15.00SP	-	1080
1.0	C10P015P4	-	15.00SP	-	1080
1.2	C12P015P4	-	15.00SP	-	1080
1.6	C16P015P4	-	15.00SP	-	1080
1.6	C16D380A4	-	380.00BDF	-	760

0.6	C06P005R6	-	5.00SP	-	1000
0.8	C08P005R6	-	5.00SP	-	1000
0.9	C09P005R6	-	5.00SP	-	1000
1.2	801262	-	5.00SP	-	1000
0.8	8180815	-	15.00SP	-	1080
0.9	8180915	-	15.00SP	-	1080
1.0	8181015	-	15.00SP	-	1080
1.2	8181215	-	15.00SP	-	1080
0.8	810745	-	15.00SP	-	1080
0.9	812916	-	15.00SP	-	1080
1.2	810769	-	15.00SP	-	1080
1.6	C16P015P6	-	15.00SP	-	1080
0.9	C09D250A6	-	250.00BDF	-	1000
1.0	C10D250A6	-	250.00BDF	-	1000
1.2	C12D250A6	-	250.00BDF	-	1000

0.6	12-8656	-	5.00SP	-	1000
0.8	12-8658	-	5.00SP	-	1000
0.9	12-8659	-	5.00SP	-	1000
0.6	12-8606	-	15.00SP	-	900
0.8	12-8608	-	15.00SP	-	900
0.9	12-8609	-	15.00SP	-	900
1.0	12-8610	-	15.00SP	-	900
1.2	12-8612	-	15.00SP	-	900
0.9	12-8209	-	250.00BDF	-	1000
1.2	12-8212	-	250.00BDF	-	1000

Stainless Steel

Lincoln Electric[®] stainless steel MIG wires can be used in all welding positions. Flat and horizontal welding, globular and spray metal transfer modes are recommended. For out-of-position welding use dip/short-circuiting or pulsed transfer modes. Recommended shielding gases include Argon/Oxygen blends. Contact Lincoln Electric[®] Australia for more detailed product information or procedural recommendations.

Lincoln[®] 308LSi

Classification: AS 2717.3: ES308LSi
 AWS A5.9: ER308LSi

Designed for welding '18-8' type stainless steels such as 302/304/304L (wrought) and CF-3/CF-8 (cast). Deposit is highly resistant to oxidation and corrosion.

Lincoln[®] 316LSi

Classification: AS 2717.3: ES316LSi
 AWS A5.9: ER316LSi

Designed for welding Mo bearing austenitic stainless steels such as 316/316L (wrought) and CF-3M/CF-8M (cast). Deposit is highly resistant to oxidation and corrosion, especially pitting corrosion. It should not be used for service in urea manufacture.

Lincoln[®] 309LSi

Classification: AS 2717.3: ES309LSi
 AWS A5.9: ER309LSi

For welding 304L/309 (wrought) and CF-3/CH-20 (cast) base materials. A high Cr austenitic stainless steel electrode for applications where improved corrosion and oxidation resistance are required. Also used for dissimilar metals joining such as stainless steel to carbon/low alloy steel.

Silicon Bronze

Classification: AWS 5.7:ERCuSi-A

Copper-based alloy suitable for welding galvanised steel and for lower strength brazing type applications on light gauge steel section. Also suitable for welding Copper-Zinc alloys to themselves and steel.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
0.8	331088	-	15.00SP	-	900
0.9	331089	-	15.00SP	-	900
1.2	331082	-	15.00SP	-	900
1.6	331086	-	15.00SP	-	900

0.8	331068	-	15.00SP	-	900
0.9	331069	-	15.00SP	-	900
1.2	331062	-	15.00SP	-	900
1.6	331066	-	15.00SP	-	900
0.9	336009	-	200.00BDF	-	900
1.2	336002	-	200.00BDF	-	900

0.8	331098	-	15.00SP	-	900
0.9	331099	-	15.00SP	-	900
1.2	331092	-	15.00SP	-	900
1.6	331096	-	15.00SP	-	900

0.9	94004703	-	13.6SP	-	816
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Aluminium

Lincoln Electric's range of premium Super Glaze® aluminium MIG wires cover the industries most commonly used alloy grades. Super Glaze® products are manufactured to tight specifications on alloy chemistry and surface finish and are subject to rigorous control measures to assure quality. Contact Lincoln Electric® Australia for detailed information on aluminium consumables and their applications.

Super Glaze® 4043

Classification: AS 2717.2: E4043
AWS A5.10: ER4043

For the welding of heat-treatable base alloys and more specifically the 6XXX series alloys. It has a lower melting point and more fluidity than the 5XXX series filler alloys and is preferred by welders because of its favourable operating characteristics. ER4043 type wires are also less sensitive to weld cracking with the 6XXX series base alloys. Super Glaze® 4043 is suitable for sustained elevated temperature service, ie. above 65°C.

Super Glaze® 5183

Classification: AS 2717.2: E5183
AWS A5.10: ER5183

Designed to weld high magnesium alloys to meet higher tensile strength requirements. Use on 5083 and 5654 base materials when required tensile strengths are 276 MPa (40,000 psi) or greater. Typical applications are in the marine and cryogenic industries, and high strength structural aluminium fabrication.

Super Glaze® 5356

Classification: AS 2717.2: E5356
AWS A5.10: ER5356

UltraMag™ S6 has the highest level of manganese and silicon and can be used when welding on materials with a medium to high presence of dirt, rust or mill scale. In addition UltraMag™ S6 produces a more fluid weld pool and is an excellent choice when bead appearance is important.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
0.9	ED028395	-	7.26SP	-	849.42
0.9	ED028395A	-	7.26SP	-	849.42
1.2	ED028397A	-	7.26SP	-	849.42
1.6	ED028398A	-	7.26SP	-	849.42
0.9	ED028435	-	7.26SP	-	849.42
0.9	ED028435A	-	7.26SP	-	849.42
1.2	ED028437A	-	7.26SP	-	849.42
1.6	ED028438A	-	7.26SP	-	849.42
2.4	ED028439A	-	7.26SP	-	849.42
0.9	ED028385A	-	7.26SP	-	849.42
1.0	ED028386A	-	7.26SP	-	849.42
1.2	ED028387A	-	7.26SP	-	849.42
1.6	ED028388A	-	7.26SP	-	849.42

Outershield®

Outershield®, our flux-cored and metal-cored wire product line, is well suited to a wide range of general fabrication and structural applications: fillet, lap and butt welds, single and multi-pass. Some of the products features include: use with CO₂ and Argon blend gases, excellent deposition efficiency, consistent arc characteristics providing easy weld pool control in all welding positions and easy slag removal. Welders all over the world choose Outershield® wires for reliability and performance.

Outershield® 70

Classification: AS 2203.1: ETD-GCp-W502A.
CM1.H10
AWS A5.20: E70T-1C

The ideal choice for flat and horizontal groove and fillet welds where high deposition rates are important. Outershield® 70 is also appealing as it returns optimum welding performance on materials with high levels of rust, oil or mill scale. Recommended shielding – 100% CO₂.

Outershield® 70-CX



Classification: AS 2203.1: ETD-GCp-W502A.
CM1.H10
AWS A5.20: E70T-1C

Designed and manufactured in Australia, Outershield® 70-CX is a down hand only rutile based electrode. Outershield® 70-CX provides an extremely smooth arc transfer with excellent 'ease of use'. Excellent for downhand high speed fillets, even over rusty plate. Outershield® 70-CX produces a clean surface finish under 100% CO₂ shielding gas.

LW-71

Classification: AS 2203.1:
ETP-GCp-W503A.CM1.H10
AWS A5.20: E70T-1C,
9C & 12C H8

LW-71 is a gas shielded, rutile basic general purpose, micro-alloyed, flux-cored welding wire designed for all position welding of mild steel in applications requiring moderate levels of strength and very good notch toughness. Recommended shielding – 100% CO₂.

Outershield® 81Ni-H

Classification: AS 2203.1:
ETP-GMp-W554A.Ni1.H5
AWS A5.29:
E81T1-Ni1M H8

A low alloy (1%Ni) wire depositing weld with excellent impact resistance and proven performance in restrained joint applications. Easy to use with smooth arc characteristics. Designed to deliver X-ray quality welds for the petrochemical, offshore drilling and mining industries. An economic, high deposition rate replacement for E5518-C3 electrodes. Recommended shielding – 5-25% CO₂ in Argon.

Outershield® 81K2-H

Classification: AS 2203.1:
ETP-GMp-W554A.K2.H5
ETP-GMp-W554P.K2.H5
AWS A5.29: E81T1-K2M

A slightly higher nickel (1.5%) weld deposit than 81Ni1-H. Typical Charpy V-notch results of 65J at -40°C, with superior CTOD values. Excellent slag removal, maximising welding time. A proven performer on offshore drilling rigs. The wire of choice for critical applications requiring superior mechanical properties in both the as-welded and stress relieved conditions. Recommended shielding – 5-25%CO₂ in Argon.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.6	ED012782	-	22.68C	K303/KA1009	1361
2.0	ED012785	-	22.68C	K303/KA1009	1361

2.4	033624	-	25C	K303/KA1009	900
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1.6	COELW71P21	-	15.00SP (VRB)	K303/KA1009	1080
2.0	COELW71P61	-	15.00SP (VRB)	K303/KA1009	1080

1.2	941357	-	15.00WB	KA1321	840
2.0	942750	-	15.00WB	KA1321	840

1.2	941395	-	15.00WB	KA1321	840
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FCAW (Flux cored)

Consumables

Outershield® 690-H

Classification: AS 2203.1: ETP-GMp-W768A.
K3
AWS A5.29: E111T1-K3MJ H4

This wire is quite impressive. Excellent running characteristics in all welding positions. Capable of delivering, matching, full strength butt welds of high strength quenched and tempered steels such as Bisplate 80. Typical Charpy V-notch results >50J at -40°C. Recommended shielding – 5-25%CO₂ in Argon.

Outershield® MC-710



Classification: AS 2203.1: ETP-GMp-W503A.
CM1.H10
AWS A5.18: E70C-6M

High deposition rate, metal cored wire with less smoke, spatter and slag (virtually none) than comparable wires. If high welding speed/high productivity are the priority, MC-710 will easily weld as fast as you can. A smart economic choice for high productivity, high volume fabrication and production welding. Will suit robotic applications. Recommended shielding – 5-25%CO₂ in Argon.

Outershield® MC-715-H

Classification: AS 2203.1:
ETP-GMp-504A.CM1.H5
ETP-GMp-404P.CM1.H5
AWS A5.20: E71T-5MJ
E70C-6M H4

Whilst a quality metal cored wire in it's own right, MC-715-H can also be used as an alternative to other basic FCAW wires. High deposition rates, excellent arc characteristics and minimal spatter or slag make this wire score well on operator appeal. Deposits a very low hydrogen weld, <5ml/100g weld deposit, with excellent Charpy V-notch results, >47J at -40°C. Recommended shielding – 5-25%CO₂ in Argon.

Outershield® 71-MX



Classification: AS 2203.1: ETP-GMp-W503A.
CM1.H10
AWS A5.20:
E71T-1M, 9M & 12M H8

Designed and manufactured in Australia, Outershield® 71MX is an all positional Rutile-based Microalloyed electrode, providing excellent operator appeal, producing sound welds, with a clean surface finish under mixed gas. Recommended Shielding – 5-25% CO₂ in Argon.

Outershield® 71-CX



Classification: AS 2203.1:
ETP-GCp-W503A.CM1. H10
AWS A5.20:
E71T-1C, 9C & 12C H8

Designed and manufactured in Australia, Outershield® 71CX is an all positional rutile- based micro-alloyed electrode. 71CX provides an extremely smooth arc transfer, with excellent 'ease of use' making good out of position welds with a clean surface finish under 100% CO₂ shielding gas. Recommended Shielding – 100% CO₂.

460VD-H

Classification: AS 2203.1:
ETD-GMn/p-W503A.CM1 H5
ETP-GMn/p-W503A.CM1
AWS A5.18: E70C-6M H4

Metal Cored wire for welding with high efficiency. Especially for vertical down full strength butt and fillet welding in lighter plate. Excellent Arc characteristics give outstanding operator appeal. Very little slag, Extremely fast travel speed. Recommended Shielding – 5-25% CO₂ in Argon.

G70M

Classification: AS 2203.1: ETP-GMp-W503A.
CM1. H10
AWS A5.20:
E71T-1MJ, 9MJ H8

Pipeliner® G70M is designed to deliver outstanding weld properties for semi-automatic applications, particularly on pipe work. Robust impacts mean consistently high CVN values. All position single and multiple pass wire designed to join pipe up to X70. Recommended Shielding – 5-25% CO₂ in Argon.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.2	942460	-	22.68C	KA1321	840
1.6	942477	-	22.68C	KA1321	840

1.2	033101	-	15.00SP	-	1080
1.6	033102	-	15.00SP	-	1080

1.6	942033	-	15.00WB	KA1321	840
2.0	942040	-	15.00WB	KA1321	840

1.2	033502	-	13.00SP	-	936
1.6	033506	-	13.00SP	-	936

1.2	033602	-	13.00SP	-	936
1.6	033606	-	13.00SP	-	936

1.2	942859	-	15.00SSP	-	750
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1.2	ED030926	-	4.54SP (VFB)	-	204
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Innershield[®]

Lincoln Electric's Innershield[®] wires are user-friendly, convenient and versatile. All shielding, slagging and deoxidising materials are built into the flux core, hence no external shielding. Lincoln Electric's range of Innershield[®] wires is extensive. Lincoln Electric[®] Australia has several Innershield[®] wires to choose from providing a wire well suited for most applications. Each wire has been designed to deliver optimum arc characteristics. Some applications of Innershield wires include bridges, offshore drilling rigs, line pipe and many other outdoor applications where wind is a factor.

Innershield[®] NR-152

Classification: AS 2203.1: ETPS-GNn-W500A
 AWS A5.20: E71T-14

Designed for high speed, single pass, semi-automatic and automatic welding on 0.8-4.8mm thickness steels. Welding characteristics have been optimised for galvanised, zinc coated or aluminised steels.

Innershield[®] NR-211-MP

Classification: AS 2203.1: ETP-GNn-W500A.CM2.H15
 AWS A5.20: E71T-11



An easy-to-use, versatile, general purpose wire suitable for welding in all positions without the need for procedural change. Suitable for bare and coated (galvanised etc.) steels of thickness up to 12mm. Not suitable for applications requiring good Charpy V-notch properties. Consistent arc characteristics, low spatter and excellent bead appearance continue to reinforce '211-MP's' position as a trusted, high quality and reliable general purpose wire.

Steelcore[™] 71T-GS

Classification: AS/NZS 17632-B T49
 Z TG-1NA-H15;
 AWS A5.20 E71T-GS

All positional self shielded flux-cored electrode designed primarily for single pass welds on carbon steels up to 5mm maximum thickness. Especially suited for the welding of galvanised and zinc coated steels.

Innershield[®] NR-212

Classification: AS 2203.1: ETP-GNn-W500A.G.H15
 AWS A5.29: E71TG-G



An alternative general purpose wire to Innershield[®] NR-211-MP when welding plate greater than 12mm thickness. Shares many of the excellent performance characteristics of NR-211-MP: semi-automatic and automatic welding, single and multi-pass, low spatter, excellent bead appearance, handles poor fit-up, bare and coated steels, robotic applications. Not suitable for applications requiring good Charpy V-notch properties.

Innershield[®] NR-207

Classification: AS 2203.1: ETP-GNn-W509A.K6.H15
 AWS A5.29: E71T8-K6

Designed for optimum performance on vertical down hot, fill and cap passes on cross country pipelines and arctic grade pipe. Use Innershield[®] NR-207 instead of MMAW electrode to significantly improve productivity on line pipe welding projects. Excellent crack resistance and outstanding Charpy V-notch and CTOD properties. Suitable for welding API 5L Grade X42 to X70 pipe material.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.7	ED012186	-	22.68C	K303/KA1009	1219

0.9	ED016354	-	4.54SP	-	204
1.2	ED016363	-	4.54SP	-	204
1.2	ED030638	-	11.34SSP	-	1021
1.7	KC211176MP	-	24.00CT (6.00C)	K435	864
1.7	KC2111712MP	-	12.50SP	-	900
2.0	KC211206MP	-	24.00CT (6.00C)	K435	864
2.0	KC2112012MP	-	12.50SP	-	900

0.8	14-1382	-	0.9SP	-	-
0.9	14-1383	-	0.9SP	-	-
0.8	14-1392	-	4.5SP	-	204
0.9	14-1393	-	4.5SP	-	204
1.2	14-1395	-	4.5SP	-	204

1.2	ED030639	-	11.34SSP	-	1021
1.7	ED030642	-	11.34SSP	-	1021
2.0	ED030646	-	11.34SSP	-	1021

2.0	KC207206	-	24PP (6.00C)	K435	576
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FCAW (Flux cored)

Consumables

Innershield® (cont.)

Innershield® NR-232

Classification: AS 2203.1:
ETP-GNn-W503A.CM1.H15
AWS A5.20: E71T-8

Innershield® NR-232 delivers one of the highest deposition rates for out-of-position welding of all the Innershield® wires. Suitable for single and multipass welding applications on carbon steel and some low alloy steels 4.8mm and thicker. Will meet minimum Charpy V-notch properties required for seismic applications.

Innershield® NR-233



Classification: AS 2203.1:
ETP-GNn-W503A.CM1.H15
AWS A5.20: E71T-8

Innershield® NR-233 uses advanced Microflux® technology to deliver outstanding mechanical properties and welding performance. This wire is easy to use and has high deposition rates making it a 'win-win' wire for many applications. Self-releasing slag and attractive weld appearance. Innershield® NR-233 can be used on carbon steel and some low alloy steels.

Innershield® NR-311



Classification: AS 2203.1:
ETD-GNn-W500A.CM2.H15
AWS A5.20: E71T-8

Designed to provide very high deposition rates and fast travel speeds with excellent penetration. Suitable for thicker carbon steels and some low alloy steels. A good choice for crack resistant welding on high sulphur steels. Smooth arc, easy slag removal (even in deep grooves) with high operator appeal. Not suitable for applications requiring good Charpy V-notch properties.

Innershield® NS-3M



Classification: AS 2203.1:
ETD-GNp-W500A.CM2.H15
AWS A5.20: E70T-4

Able to provide extremely high deposition rates (up to 18kg/hr) and fast travel speeds. Suitable for thicker carbon steels and some low alloy steels. Will resist cracking on high sulphur steels and porosity on steels with mildly rusty, oily or dirty surfaces. A soft, low penetrating arc with high operator appeal. Easy slag removal (even in deep grooves). Not suitable for applications requiring good Charpy V-notch properties.

Innershield® NR-208P



Classification: AS 2203.1:
ETP-Nn-W553A.G.H15
AWS A5.29: E81T8-G

Pipelinex® NR-208P is a welders first choice for welding X-65 through X-70 pipes due to its outstanding arc characteristics and performance. This product is for overmatch of yield and tensile strengths for these pipe grades. Pipelinex® NR-208P has excellent welder appeal, smooth arc action and easy slag removal making this product ideal for all welders: those with and without experience with Innershield® electrodes. Optimum performance on vertical down, hot, fill and cap passes on standard cross-country pipelines will be achieved with Pipelinex® NR-208P.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.7	ED012518	-	24.50CT (6.12C)	K435	1176
1.7	ED030643	-	11.34SSP	-	1021
1.7	ED012519	-	22.68C	K303/KA1009	1361
2.0	ED012525	-	24.50CT (6.12C)	K435	1176
2.0	ED030647	-	11.34SSP	-	1021
2.0	ED012526	-	22.68C	K303/KA1009	1361
1.6	ED030934	-	11.34SP	-	1021
1.8	ED031030	-	11.34SP	-	1021
2.0	KC311206	-	24.00CT (6.00C)	K435	840
2.4	KC3112425	-	25.00C	K303/KA1009	900
2.8	KC3112825	-	25.00C	K303/KA1009	900
2.0	KCNS32012	-	12.50SP	-	900
2.0	KCNS32025	-	25.00C	K303/KA1009	900
3.0	KCNS330200	-	200.00BRW	-	400
2.4	KCNS32425	-	25.00C	K303/KA1009	900
3.0	KCNS33025	-	25.00C	K303/KA1009	900
2.0	ED031912	-	24.00PP (6.00C)	K435	576

Stainless Steel

Lincoln[®] FC-308L

Classification: AWS A5.22: E308LT1-1 (1.2mm)
 E308LT0-1 (1.6mm)

Designed for welding '18-8' type stainless steels such as 302/304/304L (wrought) and CF-3/CF-8 (cast). Excellent weldability in all positions, exhibiting a stable arc, little spatter loss, easy slag removal and good bead appearance. Use FC-308L on DC+ only. Recommended shielding – 100% CO₂ and Ar + 20-25% CO₂.

Lincoln[®] FC-316L

Classification: AWS A5.22: E316LT1-1 (1.2mm)
 E316LT0-1 (1.6mm)

Designed for welding Mo bearing austenitic stainless steels such as 316/316L (wrought) and CF-3M/CF-8M (cast) in applications such as chemical plants. It should not be used for service in urea manufacture, as this environment will attack the ferrite. Use FC-316L on DC+ only. Recommended shielding – 100% CO₂ and Ar + 20-25% CO₂.

Lincoln[®] FC-309L

Classification: AWS A5.22: E309LT1-1 (1.2mm)
 E309LT0-1 (1.6mm)

For welding 304L/309 (wrought) and CF-3/CH-20 (cast) base materials. A high Cr austenitic stainless steel electrode for applications where improved corrosion and oxidation resistance are required. Also used for dissimilar metals joining such as stainless steel to carbon/low alloy steel. Use FC-309L on DC+ only. Recommended shielding – 100% CO₂ and Ar + 20-25% CO₂.

Lincoln[®] FC-2209

Classification: AWS A5.22: E2209T1-4 (1.2mm)

For butt and fillet welding 22Cr-5Ni-3Mo-N, duplex type stainless steels. Superior performance in all position welding with good weld pool control, slag detachability and final bead appearance. Use FC-2209 on DC+ only. Recommended shielding – Ar + 10-25% CO₂.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
1.2	332182	-	12.50SP	-	1000
1.6	332186	-	12.50SP	-	1000

1.2	332162	-	12.50SP	-	1000
1.6	332166	-	12.50SP	-	1000

1.2	332192	-	12.50SP	-	1000
1.6	332196	-	12.50SP	-	1000

1.2	332122	-	12.50SP	-	1000
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Build-Up

Lincore® 33

Classification: 1130-B7

Provides a tough, machinable, build-up or final overlay deposit for metal-to-metal wear. Ideal for rebuilding worn parts before hardfacing with more wear resistant deposits. Some applications include tractor rolls and idlers, shovel parts, mill and crusher hammers. Typical hardness (as welded) ~ 30HRC.

Lincore® 30-S

Classification: 1125-B1 [with 801,802,,880]

Submerged arc, metal cored wire depositing a moderate hardness deposit to resist metal-to-metal wear and moderate impact. Build-up, or final overlay where good machinability is required. Use with Lincolnweld® 801, 802 or 880 flux. Buildup tractor rollers, trunnions, crane wheels. Hardface track rails, shafts, idlers. Typical hardness (as welded) ~ 30HRC.

Metal-To-Metal Wear

Lincore® 36LS

Classification: 1435-B7

A single wire providing a build-up and final overlay, resistant to metal-to-metal and moderate abrasive wear. Ideal for applications where some out-of-position welding is required such as drill rods, gears and pins and other mining machinery. Can be used under flux. Available in 1.6mm diameter only. Typical hardness (as welded) ~ 36HRC.

Lincore® 40-O

Classification: 1440-B7

Provides a martensitic steel deposit that resists rolling, sliding and metal-to-metal wear. Bridges the hardness gap between Lincore® 33 and Lincore® 55. Typical applications include tractor rolls, mine car wheels, bucket links, actuating cams and crane wheels. Typical hardness (as welded) ~ 40HRC.

Lincore® 40-S

Classification: 1440-B1 [with 802,880,880M]

Submerged arc wire that resists metal-to-metal wear in rolling and sliding applications. Deposits can be: made tougher/softer by heat treatment, machined and hot forged. Provides good weld pool control and slag detachability on roundabouts. For final overlay on tractor idlers, rollers, drive sprockets and mine car wheels. Use with Lincolnweld® 880 or 802 flux. Typical hardness (as welded) ~ 40HRC.

Lincore® 55

Classification: 1855-B7

For applications requiring higher hardness for metal-to-metal wear and mild abrasion. Used on crane wheels, blower blades, rail ends and shafts. For use on carbon steel, low alloy steel and manganese steel. Typical hardness (as welded) ~ 55HRC.

Dia. (mm)	Part #	Unit weight (kg)	Adaptor req'd	Pallet weight (kg)
1.6	ED016872	9.98RR	K363	898
1.6	ED031117	11.34SSP	-	1021
2.0	ED011237	25.40CT (6.35C)	K435	1219
2.0	ED011238	22.68C	K303/KA1009	1361
2.8	ED011240	22.68C	K303/KA1009	1361
3.2	032403	25.00C	K303/KA1009	900
3.2	032413	200.00BRW	-	400
1.62	032510	12.50SP	-	900
2.8	ED025908	22.68C	K303/KA1009	1361
2.0	ED011277	25.40CT (6.35C)	K435	1219
2.0	ED017831	9.98RR	K363	898
2.0	ED031122	11.34SSP	-	1021
2.0	ED011278	22.68C	K303/KA1009	1361
2.0	ED011280	22.68C	K303/KA1009	1361
1.6	ED022056	9.98RR	K363	898
1.6	ED031134	11.34SSP	-	1021

Metal-To-Metal Wear

Lincore[®] 55-G

Classification: 1855-B5

Gas-shielded cored wire for applications requiring higher hardness for metal-to-metal wear and mild abrasion. Used on crane wheels, blower blades, rail ends and shafts. For use on carbon steel, low alloy steel and manganese steel. Recommended shielding – 25% CO₂ in Argon. Typical hardness (as welded) ~ 55HRC.

Lincore[®] T&D

Classification: 1550-B7

Produces a weld deposit similar to H12 tool steel. For build-up of tool steel dies and edges, or applying wear resistance surface on carbon or low alloy steels. Applications include punch dies and shear blades. Typical hardness (as welded) ~ 50HRC.

Abrasive Wear

Lincore[®] 60-O

Classification: 2355-B7

Resists higher levels of abrasion with moderate impact. Can be used at temperatures up to 700°C (~1300°F). Soft arc, minimum spatter, easy handling, smooth beads and low slag. Limit deposit to 2 layers. Check cracks. Applications include bucket lips, ore chutes, dozer blades and ripper teeth. Typical hardness (as welded) ~ 60HRC.

Lincore[®] 65-O

Classification: 2365-B7

Resists severe abrasion with light impact. Highest abrasion resistance and hardness of the Lincore[®] flux cored products. Similar welding characteristics to Lincore[®] 60-O. Check cracks. For use on wear plate, coal pulverizer rolls, earth engaging tools, and on slurry pipe and elbows. Typical hardness (as welded) ~ 65HRC.

Impact Loading & Abrasive Wear

Lincore[®] 50

Classification: 2150-B7

Resists abrasion with moderate impact. Larger size diameters may be used in the submerged arc process. For use on crusher rolls, dredge cutter teeth, ore chute baffles, screw flights, conveyor buckets, bulldozer grousers. Typical hardness (as welded) – 50HRC.

Dia. (mm)	Part #	Unit weight (kg)	Adaptor req'd	Pallet weight (kg)
1.2	ED028176	11.34SP	K363	1020

3.2	032403	25.00C	K303/ KA1009	900
3.2	032413	200.00BRW	-	400

1.2	ED031131	11.34SSP	-	1021
1.6	ED031132	11.34SSP	-	1021
2.0	ED019887	22.68C	K303/ KA1009	1361

2.8	ED026077	22.68C	K303/ KA1009	1361
2.8	ED026083	226.80D	K303/ KA1009	
3.2	ED026076	22.68C	K303/ KA1009	1361

1.2	ED020826	9.98RR	K363	898
1.2	ED031123	11.34SSP	-	1021
1.6	ED020827	9.98RR	K363	898
1.6	ED031124	11.34SSP	-	1021

Metal-To-Metal & Corrosion

Lincore® 96-S

Classification: 1855-B5

Submerged arc, high-carbon, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. Excellent slag removal, bead appearance and bead shape exhibiting good bead-to-bead tie-ins. For hardfacing continuous caster and steel mill rolls, rope sheaves and drums. Use with Lincolnweld® 880 or 802 flux. Typical hardness (as welded) ~ 52HRC.

Lincore® 420

Classification: 1550-B7

Submerged arc, high-carbon, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. For hardfacing continuous caster and steel mill rolls. Use with Lincolnweld® 880 or 802 flux. Typical hardness (as welded) ~ 48HRC.

Lincore® 424A

Classification: 1650-B1 [with 802]

Submerged arc, low-carbon, tough, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. For hardfacing continuous caster and steel mill rolls. Use with Lincolnweld® 880 or 802 flux. Typical hardness (as welded) ~ 40HRC.

Lincore® 423L

Classification: 1640-B1 [with 802]

Submerged arc, medium-carbon, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. Contains vanadium for resistance to softening. For hardfacing continuous caster and steel mill rolls. Use with Lincolnweld® 880 or 802 flux. Typical hardness (as welded) ~ 44HRC.

Dia. (mm)	Part #	Unit weight (kg)	Adaptor req'd	Pallet weight (kg)
3.2	032507	25.00C	K303/KA1009	900
3.2	032522	230.00BDF		
3.2	032505	25.00C	K303/KA1009	900
3.2	032512	200.00BRW	-	400
3.2	032519	250.00BDF	-	1000
3.2	032523	230.00BDF	-	
3.2	032515	230BDF	K303/KA1009	
3.2	ED018560	22.68C	-	1361
3.2	032516	200.00BRW	-	400
3.2	ED018550	272.16D	-	1088
3.2	ED018548	22.68C	K303/KA1009	1361

Special Purpose

ChainLINC[®]

Classification: 1125-B7

Submerged arc, high-carbon, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. Excellent slag removal, bead appearance and bead shape exhibiting good bead-to-bead tie-ins. For hardfacing continuous caster and steel mill rolls, rope sheaves and drums. Use with Lincolnweld[®] 880 or 802 flux. Typical hardness (as welded) ~ 52HRC.

Crushcore[®]

Classification: 2150-B7

Submerged arc, high-carbon, martensitic stainless steel deposit resistant to metal-to-metal wear, corrosion and high temperature cracking. For hardfacing continuous caster and steel mill rolls. Use with Lincolnweld[®] 880 or 802 flux. Typical hardness (as welded) ~ 48HRC.

Dia. (mm)	Part #	Unit weight (kg)	Adaptor req'd	Pallet weight (kg)
2.8	032401	25.00C	K303/ KA1009	900

2.0	032601	25.00C	K303/ KA1009	900
2.8	032600	25.00C	K303/ KA1009	900

Part #	Unit weight (kg)	Pallet weight (kg)
KC801025	25.00B	1000

KC802025	25.00B	1050
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KC880025	25.00B	1050
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KC880260	260.00BDS	1040
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KC535045	45.00B	1080
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KCQR8045050	50.00B	1200
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Fluxes

801

Classification: FBL

A neutral flux designed for use with Lincore[®] hardfacing wires. Provides smooth beads and excellent slag removal. Fast freezing slag. Use with Lincore[®] 30-S, 40-S, 420 and 96S.

802

Classification: FBL

A neutral flux designed for welding overlays with some hardfacing flux-cored and solid low alloy electrodes. Excellent overlay flux on flat and roundabout applications. Not recommended as a general purpose flux. Can be used for stainless steel. Excellent slag removal (provided correct wire selection). Excellent hot slag removal with wire containing Nb, V or very high Cr levels. Use with Lincoln[®] 423Cr and 423L. Can also be used on other 400 series martensitic stainless steel hardfacing wires.

880

Classification: FBL

A neutral flux that can be used in applications similar to 801 and 802 and may improve slag removal.

H-535

Classification: 1435-B4 [with L-60]

Alloy flux for use with Lincolnweld[®] L-60 solid wire. Produces a low-carbon, martensitic steel deposit for metal-to-metal wear and abrasion resistance. Deposit can be machinable. Hardness depends on the welding procedure and can be in the range 32-40HRC.

QR-8045

Classification: 1125-B4 [with L-60]

Alloy flux for use with Lincolnweld[®] L-60 solid wire. Produces a pearlitic steel deposit, ~25HRC, for resistance to metal-to-metal wear. Common applications include steel wheels, rolls, rails shafts etc.

SAW (Sub-arc)

Consumables

Carbon & Low Alloy Steel (Solid Wire)

Combining many years of experience, Lincoln Electric® is your best single, comprehensive resource for well-designed and well-built submerged arc welding consumables. These consumables offer controlled chemistry, consistent wire electrode diameter, controlled flux grain size, controlled flux dust levels and engineered flux particle integrity.

Lincolnweld® L-50

Classification: AS 1858.1: EM13K
AWS A5.17: EM13K

A low-carbon, medium-manganese, high-silicon special purpose wire. Suited to high speed, single pass welding on mild steel, 12mm or thinner. Use with Lincolnweld® 980 flux for an excellent flux/wire combination for all purpose semi-automatic welding.

Lincolnweld® L-60



Classification: AS1858.1: EL12
AWS A5.17: EL12

A low-carbon, low-manganese, low-silicon general purpose submerged arc wire. Primarily used for multi-pass welding but is capable of making single pass welds. Used also with Lincoln Electric® hardfacing alloy fluxes. Not for use with Lincolnweld® 960 flux.

Lincolnweld® L-61



Classification: AS1858.1: EM12K
AWS A5.17: EM12K

A low-carbon, medium-manganese, medium-silicon general purpose submerged arc wire. Tensile strengths typically higher than those with Lincolnweld® L-60 depending on flux and procedures used. Suitable for single pass welding with 700 series fluxes, particularly in cases over rust or millscale, and multi-pass welding with 860, 8500 or 882 for high strength and excellent impact properties.

Lincolnweld® L-S3



Classification: AS1858.1: EH12K
AWS A5.17: EH12K

A low-carbon, high-manganese, high-silicon wire designed for use with Lincolnweld® 880M or 8500. Lincolnweld® L-S3/8500 produces welds with 480MPa tensile strength as welded or in the stress relieved condition, as well as excellent low temperature impacts. Typical applications include offshore drilling platform legs and pressure vessels.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.0	ED011335	-	27.20C	K303/ KA1009	1469
2.4	ED011328	-	27.20C	K303/ KA1009	1469
3.2	ED011323	-	27.20C	K303/ KA1009	1469
2.0	KC602030	-	30.00C	K303/ KA1009	1080
2.4	KC602430	-	30.00C	K303/ KA1009	1080
3.2	KC603230	-	30.00C	K303/ KA1009	1080
4.0	KC604030	-	30.00C	K303/ KA1009	1080
2.4	KC6024600	-	600.00BRS	KA1298	1200
3.2	KC6032600	-	600.00BRS	KA1298	1200
4.0	KC6040600	-	600.00BRS	KA1298	1200
2.0	KC612030	-	30.00C	K303/ KA1009	1080
2.4	KC612430	-	30.00C	K303/ KA1009	1080
3.2	KC613230	-	30.00C	K303/ KA1009	1080
4.0	KC614030	-	30.00C	K303/ KA1009	1080
4.8	KC614830	-	30.00C	K303/ KA1009	1080
3.2	KC6132400	-	400.00BDF	-	1600
4.0	KC6140400	-	400.00BDF	-	1600
2.4	KC6124600	-	600.00BRS	KA1298	1200
3.2	KC6132600	-	600.00BRS	KA1298	1200
4.0	KC6140600	-	600.00BRS	KA1298	1200
2.4	030401	-	30.00C	K303/ KA1009	1080
3.2	030402	-	30.00C	K303/ KA1009	1080
4.0	030403	-	30.00C	K303/ KA1009	1080
4.0	030433	-	400.00BDF	-	1600

Carbon & Low Alloy Steel (Solid Wire)

Lincolnweld[®] L-70



Classification: AS1858.2: EA1
 AWS A5.23: EA1

A low-carbon, medium-manganese, low-silicon, 0.5% molybdenum special purpose submerged arc wire. Combine with 860 flux when multi-pass welds with 480MPa tensile strength in the stress relieved condition are required. Capable of some single pass welds with 700 series fluxes. The electrode of choice for elevated temperature applications up to 500°C. Applicable for some line pipe applications.

Lincolnweld[®] LA-71

Classification: AS1858.1: EG
 AWS A5.17: EM14K

A low-carbon, medium-manganese, high-silicon submerged arc wire fortified with titanium. Use with 860, 882 or 880M for pressure vessels, offshore platform legs or other applications requiring welds with 480MPa tensile strength as welded or after stress relieving (8 hours). Unlimited pass welds for heavy wall thickness. Lincolnweld[®] LA-71/880M is a good combination for pressure vessels requiring good low temperature impact properties.

Lincolnweld[®] LA-90

Classification: AS1858.2: EA3
 AWS A5.23: EA3

A low carbon, high manganese, high silicon, 0.5% molybdenum solid special purpose wire. Can be used with 880M on multi-pass applications requiring 620MPa minimum tensile strength. Applications include longitudinal seams on pipe requiring low temperature impact properties.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.0	KC702030	-	30.00C	K303/ KA1009	1080
2.4	KC702430	-	30.00C	K303/ KA1009	1080
3.2	KC703230	-	30.00C	K303/ KA1009	1080
3.2	KC7032400	-	400.00BDF	-	1600
3.2	KC7032600	-	600.00BRS	-	1200
4.0	ED012053	-	27.20C	K303/ KA1009	1469
4.0	KC704030	-	30.00C	K303/ KA1009	1080
4.0	KC7040600	-	600.00BRS	KA1298	1200
2.4	ED011052	-	30.00C	K303/ KA1009	1469
3.2	ED011051	-	30.00C	K303/ KA1009	1469
4.0	ED011053	-	30.00C	K303/ KA1009	1469
1.6	ED013999	-	27.20C	K303/ KA1009	1361
2.4	ED011084	-	27.20C	K303/ KA1009	1361
3.2	ED011083	-	27.20C	K303/ KA1009	1361
3.2	EDS11083	-	27.20C	K303/ KA1009	1472

SAW (Sub-arc)

Consumables

Low Alloy Steel (Cored Wire)

LAC wires have several advantages when used with neutral fluxes 880, 882, 880M and 980. These include: deposition rates as much as 50% greater at the same amperage (whilst maintaining impact properties), less variation in weld chemistry with variation in voltage, better AC welding stability, better impact properties in welds made with tandem arcs, greater resistance to hot cracking, and better overall results with extended stick-out procedures.

LAC-Ni2

Classification: AWS A5.23: ECNi2

A flux-cored wire designed for the submerged arc process. Use with 880, 882, 880M or 980 flux. Used to weld steels requiring tensile strengths of 480MPa (as welded or stress relieved) and good low temperature impact properties. Also used for welding weathering and nickel (2.5-3.5%Ni) steels.

LAC-B2

Classification: AWS A5.23: ECB2

A flux-cored wire designed for the submerged arc process. Use with 880, 882, 880M or 980 flux. Used for welding Cr-Mo steels with 1.5% Cr, 0.5% Mo or less. Designed to weld with either single or tandem arcs using a neutral flux.

LAC-M2

Classification: AWS A5.23: ECM2

A flux-cored wire designed for the submerged arc process. Use with 880, 882, 880M or 980 flux. Produces welds with yield strength around 690MPa in as welded or stress relieved condition. For welding Bisplate 80 matching strength, full strength butt welds. Delivers Charpy V-notch impacts of 20J @ -45°C.

Stainless Steel (Solid Wire)

Lincoln® 308L

Classification: AWS A5.9: ER308L

Designed for welding '18-8' type stainless steels such as 302/304/304L (wrought) and CF-3/CF-8 (cast). Excellent weldability and good bead appearance. Use with Lincolnweld® 880M flux.

Lincoln® 309L

Classification: AWS A5.9: ER309L

Designed for welding Mo bearing austenitic stainless steels such as 316/316L (wrought) and CF-3M/CF-8M (cast). It should not be used for service in urea manufacture. Use with Lincolnweld® 880M flux.

Lincoln® 316L

Classification: AWS A5.9: ER316L

For welding 304L/309 (wrought) and CF-3/CH-20 (cast) base materials. A high Cr austenitic stainless steel electrode for applications where improved corrosion and oxidation resistance are required. Also used for dissimilar metals joining such as stainless steel to carbon/low alloy steel. Not for use where the weldment will be exposed to temperatures from 540°C to 925°C. Use with Lincolnweld® 880M flux.

Lincoln® 2209

Classification: AWS A5.9: ER2209

For butt and fillet welding 22Cr-5Ni-3Mo-N, duplex type stainless steels. Superior performance and final bead appearance. Use with Lincolnweld® 880M flux.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
2.4	ED010986	-	22.68C	K303/ KA1009	1361

2.4	ED010954	-	22.68C	K303/ KA1009	1361
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4.0	ED010955	-	22.68C	K303/ KA1009	1361
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2.4	ED010981	-	22.68C	K303/ KA1009	1361
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4.0	ED010982	-	22.68C	K303/ KA1009	1361
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3.2	330083	-	25.00C	K303/ KA1009	1000
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2.4	330092	-	25.00C	K303/ KA1009	1000
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2.4	330062	-	25.00C	K303/ KA1009	1000
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3.2	330063	-	25.00C	K303/ KA1009	1000
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2.4	330222	-	25.00C	K303/ KA1009	1000
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Fluxes

Active Fluxes (700 Series) – Lincoln Electric[®] defines active fluxes as those which contain controlled amounts of manganese and/or silicon. These alloys are added as ingredients in the flux to provide improved resistance to porosity and weld cracking caused by contaminants on the plate or in the plate composition itself. The primary use for active fluxes is to make single pass welds with the fewest defects and highest quality.

761



Classification: AS1858.1: FGH

Primarily intended for single pass welding. Good appearance on large flat fillet welds. Produces weld deposits that are usually low carbon, fairly high manganese and have superior crack resistance. Excellent resistance to pockmarking. The perfect choice for AC and multiple arc welding. Excellent resistance to porosity caused by rust, scale or organic (oil) contamination.

WP70X



Classification: AS1858.1: FGH

Primarily intended for single pass welding. Welds have excellent appearance and crack resistance. Recommended for welding pipe and horizontal fillets for carbon steel plate less than 25mm thick.

780



Classification: AS1858.1: FGH

Designed for single pass welds. A favourite among operators with excellent performance characteristics making it the most common choice for a variety of applications. Low flash-through, excellent bead shape and very good slag removal.

781



Classification: AS1858.1: FSH

Designed for single pass welds on material 5mm thickness or less. Good wetting action, fast-follow characteristics for small, uniform and sound welds at high travel speed. High speed single pass welding applications. Not recommended for welding steel contaminated with rust, oil or mill scale. Do not use on multiple pass welds or heavy sections.

Neutral Fluxes (800 series) – Lincoln Electric[®] defines neutral fluxes as those which will not produce any significant change in the all-weld metal composition as a result of a large change in the arc voltage, and thus the arc length. The primary use for neutral fluxes is in multiple pass welding.

860



Classification: AS1858.1: FMM

A versatile flux that can be used in a variety of single pass and multiple pass applications. Excellent operating characteristics, and produces good impact properties when used with Lincolnweld[®] L-61 wire. For weld deposit tensile strengths of 480MPa after stress relieving (1 hour) use Lincolnweld[®] L-70 or LA-71 wires.

8500



Classification: AS1858.1: FBL

A highly basic flux designed for multiple pass welding with solid mild, low-alloy steel and with LAC electrodes. Primarily intended for applications requiring superior Charpy V-Notch impact strength at low temperatures. Good bead appearance, including in deep grooves, with straight edges and a smooth surface, free of pock marking. Use with L-S3 for applications requiring stress relief such as offshore drilling platforms, and pressure vessels.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
	KC761025	-	25.00B	-	1050
	KC761250	-	250.00BDS	-	1000
	KC70X025	-	25.00B	-	1050
	KC780025	-	25.00B	-	1050
	KC780280	-	280.00BDS	-	1120
	KC781025	-	25.00B	-	1050
	KC860025	-	25.00B	-	1050
	KC860260	-	260.00BDS	-	1040
	KC8500220	-	220.00BDS	-	880

SAW (Sub-arc)

Consumables

Fluxes

880



Classification: AS1858.1: FBL

Recommended for use with LAC wires. Use DC+ unless DC- specifically recommended for flux-cored wires. Use with some Lincore® hardfacing wires (in applications similar to 801 and 802 and may improve slag removal). Use with some stainless steel wires. Not recommended as high speed welding flux, general purpose flux for carbon steel or single arc AC welding flux. Requires clean steel (not as critical for Lincore® wires).

880M



Classification: AS1858.1: FBL

Recommended for multi-pass welding with solid mild and low-alloy steel wires, LAC wires and stainless steel wires. Designed to produce exquisite mechanical properties, including low temperature impacts. Use with both single and multiple arc welding. Provides excellent resistance to nitrogen porosity and has exceptional operating characteristics on AC. Not recommended as general purpose, fillet or high speed welding flux for mild steel. Not recommended for use with L-60. Do not use on light gauge sheet metal applications.

882



Classification: AS1858.1: FML

Designed for welding with solid mild steel, low-alloy steel and flux-cored electrodes. Use with electrodes containing minimal or no silicon. Not recommended as high speed welding flux, general purpose flux for carbon steel or single arc AC welding flux. Requires clean steel. When used with Lincolnweld® L-61 it produces deposits with a minimum of 480MPa tensile strength in the as-welded condition and excellent low temperature impacts.

Special Purpose

960



Classification: AS1858.1: FMM

A low-cost, general-purpose flux designed to weld butt joints and both single and multiple pass fillets. Performs well in a wide variety of automatic and semi-automatic applications. Produces welds with good impact strength and good slag removal. A neutral flux with most similar characteristics to 780.

995N



Classification: AS1858.1: FSM

Engineered exclusively for high speed, multi-arc welding of single pass butt joints such as longitudinal and spiral seams on pipe. Performs best on steel of greater than 12mm in thickness. For optimum Charpy impact results Lincolnweld® LA-81 wire must be used (contact Lincoln Electric® for details).

ST100



Classification: AS1858.1: FMMA2Cr

An alloy flux for use with solid stainless steel electrodes. Contains Cr to compensate for the loss of Cr in the arc. Will increase the portion of weld metal ferrite. Accommodates high travel speeds.

P223



Classification: AS1858.1: FGM

P223 is an excellent choice for pipe product on a wide range of steel grades. P223 is designed to deliver outstanding welding performance with most wire compositions. Select P223 for single or multiple wire systems in a two-run, or single pass each side system.

Dia. (mm)	Part #	Length	Unit weight (kg)	Carton weight (kg)	Pallet weight (kg)
	KC860025	-	25.00B	KC761025	1050
	KC860260	-	260.00BDS		1040
	KC880220M	-	220.00BDS	-	880
	KC882025	-	25.00B	-	1050
	KC882250	-	250.00BDS	-	1000
	KC960025	-	25.00B	-	1050
	KC9951100N	-	1100.00BB	-	1100
	KC70X025	-	22.68B	-	1050
	KC223025	-	25.00B	-	1050
	KC223220	-	220.00BDS	-	880