

PRIMACORE™ LW-75



PRIMACORE™ LW-75 is a basic type, mixed gas shielded flux-cored welding wire designed for all-position welding of mild steel in applications requiring excellent hot and cold crack resistance and high impact toughness values. PRIMACORE™ LW-75 produces very low diffusible hydrogen and good weldability including vertical up. DC- polarity is recommended to use for welding in all positions.

APPLICATION

PRIMACORE™ LW-75 is recommended for use in welding critical applications including the fillet and butt welding of pressure vessels, offshore oil and gas platform structures and construction machinery.

CONFORMANCE

- AWS A5.20/ ASME SFA-5.20: E71T-5M-J (with 75-80% Ar / Balance CO₂, DC±)
- JIS Z 3313: T494T5-1MA-H5

LINCOLN ADVANTAGE

- Robust impact values @ -40°C
- Excellent hot and cold crack resistance
- Very low diffusible hydrogen
- Good weldability including vertical up
- Manufactured under a quality system certified to ISO 9001 and JIS requirements.

WELDING POSITIONS



PACKAGING TYPE

- All spools of wire are level layer wound on black plastic spools.
- The spools are then vacuum-packed in moisture proof, polyfoil bags.
- The spools of wire are boxed and securely stacked on wooden pallets with shrink-wrap plastic.

PRIMACORE™ LW-75**DIAMETERS / PACKAGING**

Diameter (mm)	Plastic Spools	Pallet Weight (kg)	Product No.
1.2	15kg	1080	COPLW75E21
1.4	15kg	1080	COPLW75E41
1.6	15kg	1080	COPLW75E61

MECHANICAL PROPERTIES, ALL WELD METAL

	Yield Strength (0.2% Offset) Mpa	Tensile Strength Mpa	Elongation (%)	Impact Value @-40°C (J)	Diffusible Hydrogen (ml/100g)
Requirements E71T-5M-J Per AWS A5.20	Min.390	490-670	Min.22	Min.27	4
Typical Values (*with 75-80%Ar / Balance CO₂, DC-)	430	550	27	95	<4

CHEMICAL COMPOSITION, ALL WELD METAL

	C	Si	Mn	S	P
Requirements (%) Max. E71T-5M-J Per AWS A5.20	0.12	0.90	1.75	0.03	0.03
Typical Values (*with 75-80%Ar / Balance CO₂, DC-)	0.05	0.65	1.30	0.010	0.013

* Test results and product properties listed herein for gas shielded wires have been developed with the shielding gas stated. A change of shielding gas may cause significant changes in product performance and weld metal properties. Lincoln Electric does not cover these products under warranty for use with shielding gases other than those listed in the test data.

TYPICAL OPERATING PROCEDURES

Wire Polarity ESO mm (inches)	Arc Voltage (volts)	Approx. Current (amps)	Wire Polarity ESO mm (inches)	Arc Voltage (volts)	Approx. Current (amps)
1.2mm PRIMACORE™ LW-75 DC-20 (3/4)	21-22	220-270	1.6mm PRIMACORE™ LW-75 DC-25 (63/64)	22-23	230-280
	23-24	230-290		24-25	240-280
	25-26	250-320		26-27	240-320
	27-28	260-330		28-29	260-340
	29-30	280-350		30-31	280-350
	31-32	290-360		32-33	300-370

Customer Assistance Policy

The business of 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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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.cn for any updated information.

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