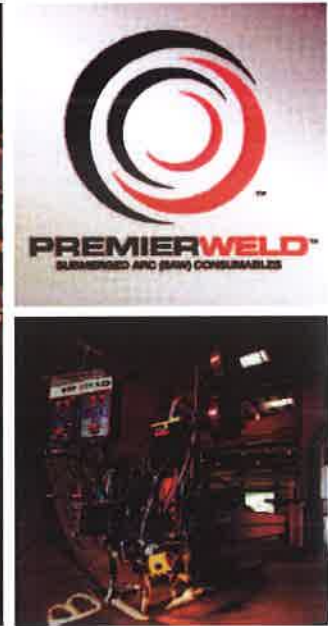


Premierweld™ IN61

AWS EM12K



KEY FEATURES

- A low carbon, medium manganese, low silicon general purpose submerged arc electrode.
- A good choice for various applications with single or multiple pass sub-arc welding
- Capable of producing weld deposits with impact value exceeding 27 J at -40 ° C when used with Lincolnweld BF-1flux

DIAMETERS / PACKAGING

Dia, mm	Coil, Kg	Drum, Kg	Product no
1.6	30		ICS61160
2.0	30		ICS61200
2.4	30		ICS61240
3.2	30		ICS61320
4.0	30		ICS61400
1.6		250	ICS61162
2.0		250	ICS61202
2.4		250	ICS61242
3.2		250	ICS61322
4.0		250	ICS61402
4.8		250	ICS61480
2.4		650	ICS61246
3.2		650	ICS61326
4.0		650	ICS61406
3.2		500 Kg reel	ICS61325R
4.0		500 Kg reel	ICS61405R
4.8		500 Kg drum	ICS61485
4.8		500 Kg reel	ICS61485R

CONFORMANCES

AWS A5.17/A5.17M: 2010

RECOMMENDED FLUXES

Lincolnweld AF-5, NF-3, BF-1, 780, 781, 960, 995N, 998N

WIRE COMPOSITION ⁽¹⁾ – As required per AWS A5.17/A5.17M: 2010

	% C	% Mn	% Si	% S	% P	% Cu
Premierweld IN61	0.05 – 0.15	0.80-1.25	0.10-0.35	0.030	0.030	0.35

(1) Single values are maximums.

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 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 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.

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