

# *SuperArc™ and SuperGlide™*

MIG WIRES



For Gas Metal Arc Welding (GMAW)



**LINCOLN®**  
**ELECTRIC**



## About The Lincoln Electric Company

*Lincoln Electric is the world's premier manufacturer of welding equipment and consumables. No company on earth is more focused on the ever-changing needs of the welding professional. Our business is all about helping companies make their welding operations more effective, more efficient, more profitable.*

*Lincoln is truly your "One Source" when it comes to welding. We're a company that continually rededicates itself to the equally important goals of exceptional quality, and exceptional service. Our field support team — with hundreds of field sales engineers and thousands of knowledgeable and responsive Lincoln distributors in countries all over the world — is the largest in the industry.*

*Innovative thinking. A quality and service-first attitude. Fresh approaches to design, manufacturing, and packaging. Worldwide strength. That's Lincoln Electric.*

## About SuperArc and SuperGlide MIG Wire

SuperArc is our premium copper coated MIG wire. SuperGlide is our premium bare MIG wire — specifically engineered for applications where the distance between wire-source and arc is significant. Both of these quality wires have well-earned reputations for feedability, consistency, and exceptional arc characteristics. We guard those reputations carefully by making sure every spool of SuperArc and SuperGlide is of the very highest quality.

### **The most demanding welders in the business demand Lincoln MIG wire.**

And they do so for some very good reasons. At Lincoln Electric, we've spent more than half a century perfecting our MIG wire. That knowledge and experience goes into every spool of SuperArc and SuperGlide we ship. Lincoln Electric is a company that's absolutely unwilling to compromise when it comes to quality. Because after all, the most demanding welders in the world are counting on us.

### **Unparalleled consistency.**

SuperArc and SuperGlide set the consistency standards by which all other MIG wires are measured — every inch perfectly stiff, with no soft spots.

That's because Lincoln utilizes the most advanced manufacturing and quality control processes in the



welding industry. It's also because nobody cares more about the quality of MIG wire than Lincoln Electric. Our team of chemists, physicists, metallurgists, welding engineers and technicians understand welding — inside and out. They make sure our SuperArc and SuperGlide wire is the best MIG wire in the world.



**Our MIG wire starts with better chemistry.**

Only the best raw material is good enough for SuperArc and SuperGlide wire. And we carefully check incoming raw steel for 19 different elements before we allow it to enter our manufacturing operation.

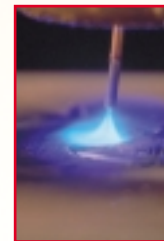
**Product and packaging options designed around your needs.**

SuperArc and SuperGlide MIG wires are available in a generous range of product and packaging configurations to meet virtually any need. No matter what you're welding — from bulldozer blades to furniture frames — there's a perfect SuperArc or SuperGlide wire for the job. These wires offer a full spectrum of diameters. And packaging options include an extensive variety of drums, spools and reels — in quantities from 2 lbs. to 1,000 lbs.

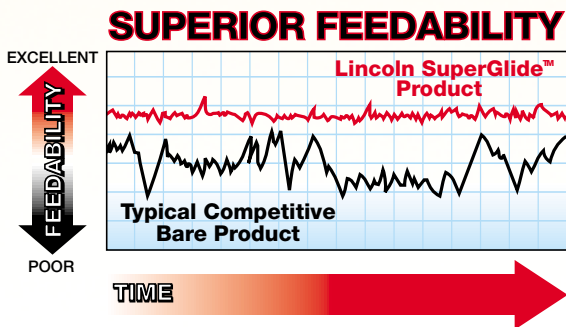
don't have time for wire that snags, tangles or kinks.

**Want a more stable arc? Choose a better wire.**

A wire that delivers a more stable arc can mean less spatter, less clean up, and improved performance. In other words, SuperArc and SuperGlide can make your welding operations more productive and more efficient. These wires are true performers — good wetting action, straight bead edges, and excellent arc characteristics. So don't let inferior wire slow you down.



Choose the wire that works as hard as you do — SuperArc and SuperGlide from Lincoln.



**Feedability that welding professionals appreciate.**

We've designed and built SuperArc and SuperGlide to be the most trouble-free wire you've ever used. Because at Lincoln, we understand that you



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# SuperArc and SuperGlide Product Selection Guide

## MILD STEEL WIRE

Product Name	AWS Classification	General Description	Page No.
<p>SuperArc L-50 (Copper Coated)</p> <p>SuperGlide S3 (Bare)</p>	ER70S-3	<p>Our most popular MIG wires, SuperArc L-50 and SuperGlide S3 are excellent choices for a broad spectrum of single-pass sheet-metal welding applications. They're also solid performers for multi-pass welds on thick steel sections.</p> <p>These Lincoln MIG wires enjoy a reputation for exceptional arc characteristics and trouble-free performance. Typical applications include industrial, farming, construction, and mining equipment. They're also a great choice when welding pipe, pressure vessels, pre-engineered steel buildings and structural steel components.</p> <p>Manufacturers — including furniture and automotive component producers all over the globe — rely on the consistent performance of our SuperArc L-50 and SuperGlide S3 wires.</p>	5
SuperArc L-52 (Copper Coated)	ER70S-2	<p>Lincoln's premium triple deoxidized wire (aluminum, titanium and zirconium).</p> <p>Our highest level of deoxidizers make SuperArc L-52 MIG wire an outstanding performer when your application calls for welding with CO<sub>2</sub> gas, or on mild steels that are dirty, rusty, or scaled.</p> <p>SuperArc L-52's less-fluid puddle makes it a great MIG wire choice when welding out-of-position, or on small diameter pipe where puddle control is essential.</p>	6
SuperArc L-54 (Copper Coated)	ER70S-4	<p>SuperArc L-54 offers a mid-range level of deoxidizers (manganese and silicon) — significantly higher than SuperArc L-50, but below the levels of SuperArc L-56.</p> <p>Thus, SuperArc L-54 is a perfect choice when welding on metals with a low-to-medium presence of dirt, rust or mill scale.</p> <p>SuperArc L-54 wire delivers enhanced wetting action, and an excellent bead profile.</p>	6
<p>SuperArc L-56 (Copper Coated)</p> <p>SuperGlide S6 (Bare)</p>	ER70S-6	<p>SuperArc L-56 and SuperGlide S6 wires offer a higher content of deoxidizers (manganese and silicon) than our L-54 product.</p> <p>Choose these MIG wires when your welding applications involve metals with a medium-to-high presence of dirt, rust or mill scale.</p> <p>SuperArc L-56 and SuperGlide S6 are excellent choices when spatter-control is important.</p> <p>These wires also produce a more fluid puddle and an excellent bead profile.</p>	7

## LOW ALLOY WIRE

Product Name	AWS Classification	General Description	Page No.
SuperArc LA-75 (Copper Coated)	ER80S-Ni1	SuperArc LA-75 is a copper coated MIG wire containing 1% nickel. This wire is a steady performer for welding weathering steel on bridges and buildings, or on cryogenic vessels or chillers.	8
SuperArc LA-90 (Copper Coated)	ER80S-D2 and ER90S-D2. Also meets ER90S-G	SuperArc LA-90 is a low carbon, high manganese, high silicon, 0.5% molybdenum wire. This quality product is an excellent choice for applications where tensiles are in excess of 80-90,000 psi (552-620 MPa), or when strength after stress relief is crucial. Typical applications include high temperature service piping and blowers, cranes, construction equipment and power plants.	8
SuperArc LA-100 (Copper Coated)	ER100S-G and also meets ER110S-G and MIL-100S-1	SuperArc LA-100 produces deposits with a minimum 82,000 psi (566 MPa) yield strength when welded at high heat inputs. This low alloy wire is designed for optimum performance on HY-80 and T1 steels, military ships and submarines.	9

**SuperArc L-50 and SuperGlide S3**

SuperArc L-50 is a copper coated wire, SuperGlide S3 is bare. Both are low carbon, medium manganese, high silicon wires, and are excellent choices for single pass welding. They can also be used for multiple pass applications, especially on killed or semi-killed steels.

**AWS Electrode Composition Requirements**

**%C** .06-.15, **%Mn** .90-1.40, **%Si** .45-.75, **%S** .035, **%P** .025, **%Cu** .50

Note: Single values are maximum.

**Typical Shielding Gases**

100% CO<sub>2</sub>, 75-95% Ar/Balance CO<sub>2</sub>,  
95-98% Ar/Balance O<sub>2</sub>

**Diameters**

.030\*, .035, .040\*, .045, .052, 1/16 in.  
(0.8\*, 0.9, 1.0\*, 1.1, 1.3, 1.6 mm)  
\* L-50 only.

***“Downtime can be devastating to a manufacturing operation’s bottom-line. That’s why we’re so particular about the way we build our SuperArc wire. It won’t let you down.”***

**Brian Jackson**  
**Manufacturing Manager**  
**Consumables**

**MECHANICAL PROPERTIES**

Wire Type	Test Conditions	Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elongation (%)	Charpy V-Notch, ft-lbs (J)		
					@ 0°F (-18°C)	@-20°F (-29°C)	@-40°F (-40°C)
SuperArc L-50 SuperGlide S3	<b>REQUIREMENTS</b>						
	ER70S-3 per AWS A5.18 AW with CO <sub>2</sub>	70,000 min. (483)	58,000 min. (400)	22 min.	20 min. (27)	Not Specified	Not Specified
	MIL-70S-3 per MIL-E-23765/1 AW with CO <sub>2</sub> and 98Ar/2O <sub>2</sub>	70,000 min. (483)	55,000 - 70,000 (379 - 483)	22 min.	Not Specified	Not Specified	Not Specified
	MIL-70S-3 per MIL-E-23765/1 SR <sup>(2)</sup> with CO <sub>2</sub> and 98Ar/2O <sub>2</sub>	70,000 min. (483)	52,000 min. (358)	26 min.	Not Specified	20 min. (27)	Not Specified
	<b>TEST RESULTS</b>						
	AW with CO <sub>2</sub>	76,200 (525)	63,700 (439)	30	70 (95)	65 (88)	18 (24)
	SR <sup>(1)</sup> with CO <sub>2</sub>	68,900 (475)	52,800 (364)	34	87 (118)	74 (100)	65 (88)
	AW with 75Ar/25CO <sub>2</sub>	78,700 (543)	63,900 (441)	27	78 (106)	75 (102)	60 (81)
	SR <sup>(1)</sup> with 75Ar/25CO <sub>2</sub>	70,700 (487)	53,100 (366)	33	122 (165)	120 (163)	104 (141)
	AW with 90Ar/10CO <sub>2</sub>	79,200 (546)	67,700 (467)	22	105 (142)	90 (122)	65 (88)
SR <sup>(1)</sup> with 90Ar/10CO <sub>2</sub>	70,200 (484)	53,300 (367)	35	—	158 (214)	146 (198)	
AW with 98Ar/2O <sub>2</sub>	77,700 (536)	62,100 (428)	27	80 (108)	70 (95)	60 (81)	
SR <sup>(1)</sup> with 98Ar/2O <sub>2</sub>	68,500 (472)	51,000 (352)	33	—	250 (339)	132 (179)	

AW - As welded. SR<sup>(1)</sup> - Stress relieved 1 hour at 1150°F (621°C). SR<sup>(2)</sup> - Stress relieved 2 hours at 1125°F (607°C).

**L-52**

This copper coated wire's deoxidizers — including aluminum, titanium and zirconium — make it a great choice for welding on material with light rust, scale or dirt. SuperArc L-52's weld puddle is less fluid than most, aiding in out-of-position and small diameter pipe welding. This is a triple deoxidizing, low carbon, medium manganese, high silicon wire.

**AWS Electrode Composition Requirements**

**%C** .07, **%Mn** .90-1.40, **%Si** .40-.70, **%S** .035, **%P** .025, **%Cu** .50, **%Al** .05-.15, **%Ti** .05-.15, **%Zr** .02-.12

Note: Single values are maximum.

**Typical Shielding Gases**

100% CO<sub>2</sub>, 75-80% Ar/Balance CO<sub>2</sub>

**Diameters**

.035, .045 in. ( 0.9, 1.1 mm)

**L-54**

SuperArc L-54 is a low carbon, medium manganese, high silicon wire that welcomes materials with small amounts of rust and dirt. This copper coated wire performs well in applications that require a greater alloy content.

**AWS Electrode Composition Requirements**

**%C** .07-.15, **%Mn** 1.00-1.50, **%Si** .65-.85, **%S** .035, **%P** .025, **%Cu** .50

Note: Single values are maximum.

**Typical Shielding Gases**

100% CO<sub>2</sub>, 75-95% Ar/Balance CO<sub>2</sub>,  
95-98% Ar/Balance O<sub>2</sub>

**Diameters**

.035, .045, .052 in. (0.9, 1.1, 1.3 mm)

**MECHANICAL PROPERTIES**

Wire Type	Test Conditions	Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elongation (%)	Charpy V-Notch, ft-lbs (J)		
					@ 0°F (-18°C)	@-20°F (-29°C)	@-40°F (-40°C)
SuperArc L-52	<b>REQUIREMENTS</b> ER70S-2 per AWS A5.18 AW with CO <sub>2</sub>	70,000 min. (483)	58,000 min. (400)	22 min.	Not Specified	20 min. (27)	Not Specified
	<b>TEST RESULTS</b> AW with CO <sub>2</sub> SR <sup>(1)</sup> with CO <sub>2</sub>	79,100 (545) 75,700 (522)	70,000 (483) 63,400 (437)	29 30	31 (42) 46 (62)	23 (31) 30 (41)	— 30 (41)
	AW with 75Ar/25CO <sub>2</sub> SR <sup>(1)</sup> with 75Ar/25CO <sub>2</sub>	85,600 (590) 85,400 (589)	78,600 (542) 73,300 (505)	27 28	69 (93) 50 (68)	39 (53) 22 (30)	— —
SuperArc L-54	<b>REQUIREMENTS</b> ER70S-4 per AWS A5.18 AW with CO <sub>2</sub>	70,000 min. (483)	58,000 min. (400)	22 min.	Not Specified	Not Specified	Not Specified
	<b>TEST RESULTS</b> AW with CO <sub>2</sub> SR <sup>(1)</sup> with CO <sub>2</sub>	80,700 (556) 72,200 (498)	67,500 (465) 53,600 (370)	30 35	85 (115) 92 (125)	75 (102) 90 (122)	40 (54) 75 (102)
	AW with 75Ar/25CO <sub>2</sub> SR <sup>(1)</sup> with 75Ar/25CO <sub>2</sub>	83,400 (575) 76,000 (524)	72,000 (496) 60,400 (416)	26 35	105 (142) 122 (165)	70 (95) 114 (155)	75 (102) 95 (129)
	AW with 90Ar/10CO <sub>2</sub> SR <sup>(1)</sup> with 90Ar/10CO <sub>2</sub>	82,500 (569) 75,200 (518)	72,200 (498) 57,900 (399)	23 36	115 (156) 193 (262)	105 (142) 145 (196)	65 (88) 105 (142)
	AW with 98Ar/2O <sub>2</sub> SR <sup>(1)</sup> with 98Ar/2O <sub>2</sub>	79,200 (546) 73,000 (503)	66,200 (456) 54,100 (373)	24 36	140 (190) 260 (352)	125 (169) 145 (196)	95 (129) 140 (190)

AW - As welded. SR<sup>(1)</sup> - Stress relieved 1 hour at 1150°F (612°C).

**“Partnering with Lincoln Electric has resulted in very significant cost savings in our welding-related operations.”**



**James MacLellan**  
The Holland Binkley Company  
Warrinton, Missouri

**SuperArc L-56 and SuperGlide S6**

SuperArc L-56 and SuperGlide S6 offer improved mechanical properties, bead appearance and higher strength when a higher alloy content (manganese and silicon) is required. These wires are low carbon, high manganese, and very high silicon. SuperArc L-56 is a copper coated wire, SuperGlide S6 is bare wire.

**AWS Electrode Composition Requirements**

**%C** .06-.15, **%Mn** 1.40-1.85, **%Si** .80-1.15, **%S** .035, **%P** .025, **%Cu** .50

Note: Single values are maximum.

**Typical Shielding Gases**

100% CO<sub>2</sub>, 75-95% Ar/Balance CO<sub>2</sub>, 95-98% Ar/Balance O<sub>2</sub>

**Diameters**

.025\*, .030\*, .035, .040\*, .045, .052, 1/16 in.  
(0.6\*, 0.8\*, 0.9, 1.0\*, 1.1, 1.3, 1.6 mm)  
\* L-56 only.

**MECHANICAL PROPERTIES**

Wire Type	Test Conditions	Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elongation (%)	Charpy V-Notch, ft-lbs (J)		
					@ 0°F (-18°C)	@-20°F (-29°C)	@-40°F (-40°C)
SuperArc L-56 SuperGlide S6	<b>REQUIREMENTS</b>						
	ER70S-6 per AWS A5.18 AW with CO <sub>2</sub>	70,000 min. (483)	58,000 min. (400)	22 min.	Not Specified	20 min. (27)	Not Specified
	MIL-70S-6 per MIL-E-23765/1 AW with CO <sub>2</sub> and 98Ar/2O <sub>2</sub>	70,000 min. (483)	55,000 - 80,000 (379 - 552)	22 min.	Not Specified	Not Specified	Not Specified
	MIL-70S-6 per MIL-E-23765/1 SR <sup>(2)</sup> with CO <sub>2</sub> and 98Ar/2O <sub>2</sub>	70,000 min. (483)	52,000 min. (358)	26 min.	Not Specified	20 min. (27)	Not Specified
	<b>TEST RESULTS</b>						
	AW with CO <sub>2</sub>	81,800 (564)	67,900 (468)	29	45 (61)	40 (54)	27 (37)
	SR <sup>(1)</sup> with CO <sub>2</sub>	74,200 (512)	56,600 (390)	29	85 (115)	70 (95)	50 (68)
	SR <sup>(2)</sup> with CO <sub>2</sub> AW with 75Ar/25CO <sub>2</sub>	77,800 (536) 85,000 (586)	60,900 (420) 74,700 (515)	31 29	88 (119)	80 (108)	70 (95)
	SR <sup>(1)</sup> with 75Ar/25CO <sub>2</sub> AW with 90Ar/10CO <sub>2</sub>	78,000 (538) 85,200 (587)	60,400 (416) 71,000 (489)	31 22	110 (149) 160 (217)	103 (140) 145 (196)	90 (122) 140 (190)
	SR <sup>(1)</sup> with 90Ar/10CO <sub>2</sub> AW with 98Ar/2O <sub>2</sub>	79,200 (546) 82,100 (566)	64,200 (443) 66,200 (456)	32 27	160 (217) 120 (163)	135 (183) 90 (122)	115 (156) 80 (108)
SR <sup>(1)</sup> with 98Ar/2O <sub>2</sub> SR <sup>(2)</sup> with 98 Ar/2O <sub>2</sub>	78,500 (541) 79,500 (548)	60,400 (416) 63,400 (437)	34 33	160 (217)	140 (190) 115 (156)	130 (176)	

AW - As welded. SR <sup>(1)</sup> - Stress relieved 1 hour at 1150°F (612°C). SR <sup>(2)</sup> - Stress relieved 2 hours at 1125°F (607°C).

**LA-75**

SuperArc LA-75 is a low alloy wire designed for applications that demand excellent low temperature impacts, or when the work involves a color match on weathering steels. SuperArc LA-75 is a medium manganese, high silicon wire with approximately 1% nickel.

**AWS Electrode Composition Requirements**

%C .12, %Mn 1.25, %Si .40-.80, %S .025, %P .025, %Ni .80-1.10, %Cr .15, %Mo .35, %V .05, %Cu .35

Note: Single values are maximum.

**Typical Shielding Gases**

75-95% Ar/Balance CO<sub>2</sub>,  
95-98% Ar/Balance O<sub>2</sub>

**Diameters**

.035, .045 in. (0.9, 1.1 mm)

**LA-90**

SuperArc LA-90 is designed for optimum performance where tensiles in excess of 80-90,000 psi are required, or when strength after stress relief is crucial. SuperArc LA-90 is a low carbon, high manganese, high silicon, .5% molybdenum wire.

**AWS Electrode Composition Requirements**

%C .07-.12, %Mn 1.60-2.10, %S .025, %Si .50-.80, %P .025, %Cu .50, %Ni .15, %Mo .40-.60

Note: Single values are maximum.

**Typical Shielding Gases**

100% CO<sub>2</sub>, 75-95% Ar/Balance CO<sub>2</sub>,  
95-98% Ar/Balance O<sub>2</sub>

**Diameters**

.035, .045, .052, 1/16 in. (0.9, 1.1, 1.3, 1.6 mm)

**MECHANICAL PROPERTIES**

Wire Type	Test Conditions	Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elongation (%)	Charpy V-Notch, ft-lbs (J)			
					@ -50°F (-46°C)	@ -75°F (-59°C)	@ -100°F (-73C)	
SuperArc LA-75	<b>REQUIREMENTS</b> AW with 90Ar/10CO <sub>2</sub> ER80S-Ni1 per AWS A5.28	80,000 min. (552)	68,000 min. (469)	24 min.	20 min. (27)	Not Specified	Not Specified	
	<b>TEST RESULTS</b> AW with 90Ar/10CO <sub>2</sub> SR <sup>(1)</sup> with 90Ar/10CO <sub>2</sub>	82,100 (566) 72,700 (501)	70,700 (487) 56,600 (390)	26 35	70 (95) 200 (271)	39 (53) 150 (203)	30 (41) 92 (125)	
	AW with 75Ar/25CO <sub>2</sub> SR <sup>(1)</sup> with 75Ar/25CO <sub>2</sub>	79,800 (550) 71,500 (493)	69,500 (479) 55,600 (383)	27 34	83 (112) 130 (176)	45 (61) 110 (149)	40 (54) 75 (102)	
	AW with 98Ar/2O <sub>2</sub> SR <sup>(1)</sup> with 98Ar/2O <sub>2</sub>	83,700 (577) 78,100 (538)	70,000 (483) 60,900 (420)	32 31	122 (165) 150 (203)	40 (54) 95 (129)	22 (30) 82 (111)	
SuperArc LA-90	<b>REQUIREMENTS</b> ER80S-D2 per AWS A5.28 AW with CO <sub>2</sub>	80,000 min. (552)	68,000 min. (469)	17 min.	Not Specified	20 min. (27)	Not Specified	Not Specified
	ER90S-D2 per AWS A5.28 AW with 1-5% O <sub>2</sub> , balance Ar	90,000 min. (620)	78,000 min. (540)	17 min.	Not Specified	20 min. (27)	Not Specified	Not Specified
	MIL-80S-3 per MIL-E-23765/2E SR <sup>(1)</sup> & SR <sup>(3)</sup> with 95Ar/5CO <sub>2</sub>	80,000 min. (552)	50,000 min. (345)	20 min.	30 min. (22)	Not Specified	Not Specified	Not Specified
	<b>TEST RESULTS</b> AW with Ar/CO <sub>2</sub> /O <sub>2</sub> SR <sup>(1)</sup> with Ar/CO <sub>2</sub> /O <sub>2</sub>	101,000 (696) 90,600 (625)	88,900 (613) 77,800 (536)	19 28	— —	70 (95) 90 (122)	42 (57) 80 (108)	40 (54) 75 (102)
	SR <sup>(2)</sup> with 95Ar/5CO <sub>2</sub> SR <sup>(3)</sup> with 95Ar/5CO <sub>2</sub>	96,500 (665) 89,000 (614)	84,000 (579) 76,700 (529)	28 28	145 (196) 122 (165)	— —	— —	— —
	AW with 95Ar/5O <sub>2</sub> AW with CO <sub>2</sub>	95,000 (655) 88,800 (612)	83,400 (575) 73,500 (506)	27 24	— 40 (54)	102 (138) 23 (31)	— —	— —

AW - As welded. SR<sup>(1)</sup> - Stress relieved 1 hour at 1150°F (612°C). SR<sup>(2)</sup> - Stress relieved 2 hours at 1125°F (607°C).  
SR<sup>(3)</sup> - Stress relieved 50 hours at 1125°F (607°C).



***“With Lincoln we always get a great product. But we also get fast answers and great ideas. Lincoln people make the difference.”***



***Jim Kanerva  
Waiward Steel  
Edmonton, Alberta***

**LA-100**

A low alloy wire, SuperArc LA-100 was designed to produce deposits with a minimum 82,000 psi yield strength — with excellent impact properties — when welded at high heat inputs (up to 110 KJ/in). SuperArc LA-100 is for use on HY-80 steel.

**Military Electrode Composition Requirements**

**%C** .07, **%Mn** 1.25-1.80, **%Si** .20-.55, **%S** .008, **%P** .012, **%Cu** .30, **%Ni** 1.40-2.10, **%Cr** .30, **%Mo** .25-.55, **%V** .05, **%Al** .10, **%Ti** .10, **%Zr** .10

Note: Single values are maximum.

**Typical Shielding Gases**

95-98% Ar/Balance O<sub>2</sub>,  
95% Ar/5% CO<sub>2</sub>

**Diameters**

.045, 1/16 in. (1.1, 1.6 mm)

**MECHANICAL PROPERTIES**

Wire Type	Test Conditions	Tensile Strength psi (MPa)	Yield Strength psi (MPa)	Elongation (%)	Charpy V-Notch, ft-lbs (J)	
					@ 0°F (-18°C)	@ -60°F (-51°C)
SuperArc LA-100	<b>REQUIREMENTS</b>					
	ER100S-G per AWS A5.28 (AW) (gas not specified)	100,000 min. (690)	Not Specified	Not Specified	Not Specified	Not Specified
	ER110S-G per AWS A5.28 (AW) (gas not specified)	110,000 min. (759)	Not Specified	Not Specified	Not Specified	Not Specified
	MIL-100S-1 per MIL-E-23765/2C (AW) (with 98% Ar/2%O <sub>2</sub> )	Not Specified	82,000 - 110,000	16 min.	60 min.	35 min.
	<b>TEST RESULTS</b>					
	AW @ 45 KJ/in, with 98Ar/2O <sub>2</sub>	113,000 (779)	100,000 (690)	18	—	54 (73)
	AW @ 110 KJ/in, with 98Ar/2O <sub>2</sub>	110,000 (759)	92,200 (636)	22	113 (153)	58 (79)
AW @ 30 KJ/in, with 98Ar/2O <sub>2</sub>	122,000 (841)	117,000 (807)	21	130 (176)	110 (149)	
AW @ 45 KJ/in, with 90Ar/10CO <sub>2</sub>	114,000 (786)	100,000 (690)	24	125 (169)	90 (122)	

AW - As welded.



**Accu-Trak and Speed Feed Drums**

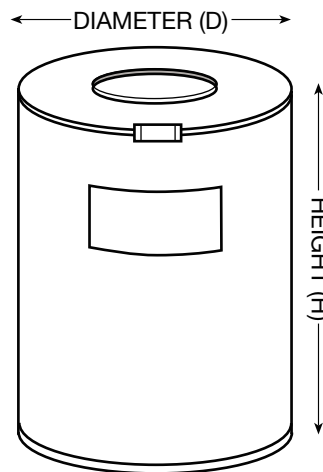
Lincoln Accu-Trak and Speed Feed Drum wire systems are bulk wire packages designed specifically for MIG wire. Built to deliver consistent performance in conventional automation and robotics, these drums also perform well in semiautomatic applications.

The Accu-Trak Drum wire system facilitates precise feeding because of a unique design that accurately places the wire in the weld joint throughout the welding process.

- The Accu-Trak Drum requires a K884-3 or K884-4 AccuTrak Drum Payoff Kit to ensure accurate feeding.
- To assist in feeding wire from Speed Feed Drums, an ED020219 Fiber Hat is recommended. See accessories on page 12 for more information.

In addition to the consistent performance of our Accu-Trak feature, our 900 lb drums are now packed

with our patented **Dense-Pack™** winding technique. This is the evolution of MIG wire drums. Improved wire feedability and reduced tangling will propel your productivity to the next level. Field-tested and approved, many customers are already experiencing improved performance and accurate wire placement. Check it out and see the difference for yourself!



**DRUM SPECIFICATIONS**

Drum Size	Diameter (D) in (mm)	Height (H) in (mm)	Core Dimensions	
			Inside Dia.	Height
<b>Speed Feed</b> 600 lb (272.2 kg)	23.4 (594)	34.8 (884)	16.0 (406)	34.0 (864)
<b>Accu-Trak</b> 500 lb (226.8 kg)	20.4 (518)	32.6 (828)	8.4 (213)	31.5 (800)
900 lb (409 kg)	23.4 (594)	34.8 (884)	6.25 (159)	34.0 (864)



**PALLET SPECIFICATIONS**

Drum Size	Pallet Weight lbs. (kg)	Dimensions Inches (mm) HxWxD
<b>Speed Feed</b> 600 lb (273 Kg)	2400 (1091)	39 x 50 x 40 (991 x 1270 x 1016)
<b>Accu-Trak</b> 500 lb (227 Kg)	2000 (909)	36 x 42 x 42 (914 x 1067 x 1067)
900 lb <sup>(1)</sup> (409 kg)	3600 (1636)	38 x 48 x 48 (965 x 1219 x 1219)

<sup>(1)</sup> Four “mini-pallets” on pallet.

### Accu-Trak

Like the Accu-Trak drum, Accu-Trak reels facilitate precise feeding because of a unique design that accurately places wire in the weld joint.

- The K895-2 Rotary Wire Dispenser fits both the Accu-Trak and Speed Feed reels. See page 12 for more information.

### Vertical and Horizontal Speed Feed Reels

Lincoln's vertical and horizontal Speed Feed reels are designed to provide maximum flexibility. Both reels are specially wound to ease feeding for steady, easy dispensing.

- Available in 300 lb., and 1000 lb. reels, vertical Speed Feed reels require a vertical dereeler to rotate the reel.
- Horizontal Speed Feed reels are available on 1000 lb. reels. Horizontal Speed Feed reels can be used with either a dereeler (which rotates the reel and provides the most accurate wire placement in the weld joint) or a Magnum Rotary Wire Dispenser.
- The K895-2 Magnum Wire Dispenser is for use with the horizontal reel, where the reel is stationary. See accessories on page 12.

VERTICAL SPEED FEED REEL

HORIZONTAL SPEED FEED REEL

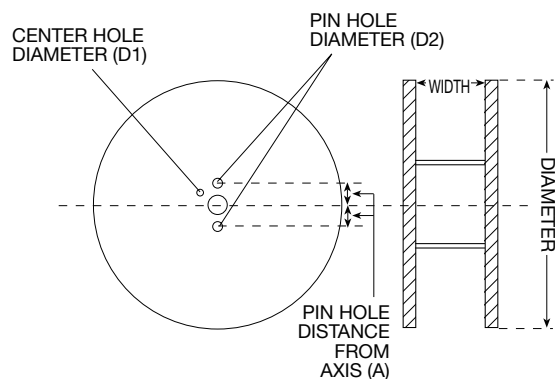


### REEL SPECIFICATIONS

Reel Size	D1 in (mm)	D2 in (mm)	A in (mm)	W in (mm)	D in (mm)
<b>Speed Feed</b> 300 lb (136 kg)	1.31 (33)	0.68 (17)	2.5 (64)	8.5 (216)	23.75 (603)
1000 lb (454 kg)	1.34 (34)	0.75 (19)	2.5 (64)	12.75 (324)	30.0 (762)
<b>Accu-Trak</b> 1000 lb (454 kg)	1.31 (33)	0.68 (17)	2.5 (64)	19.5 (495)	30.0 (762)

### PALLET SPECIFICATIONS

Reel Size	Net Weight lbs. (kg)	Dimensions Inches (mm) HxWxD	Placement on Pallet
<b>Vertical Speed Feed</b> 300 lb (136 kg)	1200 (545)	33.8 x 43.5 x 32 (859 x 1105 x 813)	4 Vertical
1000 lb. (454 kg)	3000 (1363)	33.5 x 43 x 32 (851 x 1092 x 813)	3 Vertical
<b>Horizontal Speed Feed</b> 1000 lb (454 kg)	2000 (909)	33.5 x 30 x 31.5 (851 x 762 x 800)	2 Horizontal
<b>Accu-Trak</b> 1000 lb (454 kg)	1000 (454)	23.5 x 30 x 31.5 (597 x 762 x 800)	1 Horizontal



**Accu-Trak Drum Payoff Kits**

A Payoff Kit must be used with Accu-Trak Drums to ensure precise feeding. The fitting on top of the Payoff Kit has a 1/2-14 NPT internal pipe thread to facilitate the connection of the conduit (listed below).

**For 500 lb. Accu-Trak drum, Order K884-3.**

**For 900 lb. Accu-Trak drum, Order K884-4.**



**Wire Conduits**

Plastic wire conduits are for use with the Accu-Trak Drum Payoff Kit. The "K" number needed depends on wire feeder and desired length:

**LN-7, LN-7GMA, LN-9GMA and Synergic 7**

K515-15	15 ft	(4.5 m)
K515-25	25 ft.	(7.6 m)
K515-50	50 ft.	(15.2 m)

**LN-8, LN-9 Series and NA-5R**

K565-15	15 ft.	(4.5 m)
K565-25	25 ft.	(7.6 m)
K565-50	50 ft.	(15.2 m)

**Incoming Bushings for 10-Series Wire Feeders (For LN-10, DH-10, STT-10 and Power Feed 10)**

Feed Plate Incoming Bushings connect directly to wire conduit (not included), for use in boom system, long distances, or large payoff packages. Bushings can be used with any wire conduit (K515 or K565).



**For .025-1/16" wire, Order K1546-1.**  
**For 1/16-1/8" wire, Order K1546-2.**

**Dereeler Adapter**

For mounting of competitive dispensers on Lincoln reels. Order K836-1.

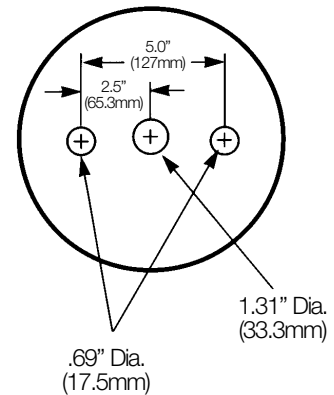


**Fiber Hat For Speed Feed Drums**

When used with the Speed Feed Drum, the reusable Magnum Fiber Hat provides continuous easy feed, without tangling. For proper dispensing, drum must rotate. Order ED020219.

**Magnum Rotary Wire Dispenser for Accu-Trak and Speed Feed Reels**

Assures smooth payoff of wire, and a unique brake mechanism helps eliminate overrun from Accu-Trak and Speed Feed reels. Can also be used on any wooden reel with a hole pattern as shown. Order K895-2.



**Small Packaging**

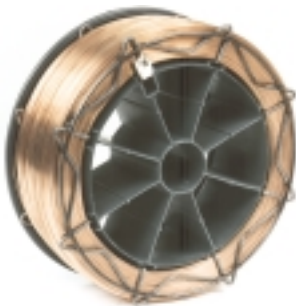
No matter what your need, Lincoln has a packaging option that offers a perfect fit. Small packaging configurations include Readi-Reels, Coils, and Spools, in quantities from 2 lbs. to 60 lbs.. Our Fiber Spools, Plastic Spools, and recyclable Eco-Spools require no adapter. (See Readi-Reel and Coil adapter options below.)



**Small Packaging Accessories** Readi-Reels, Coils and Spools

**30 Lb. Readi-Reel Adapter**

Adapts 30 lb. (13.6 kg) Readi-Reels of wire to 2" (51mm) spindle.  
Order K363P.



**60 Lb. Readi-Reel Adapter**

Adapts 60 lb. (27.2 kg) Readi-Reels of wire to 2" (51mm) spindle.  
Order K438.



**60 Lb. Coil Adapter**

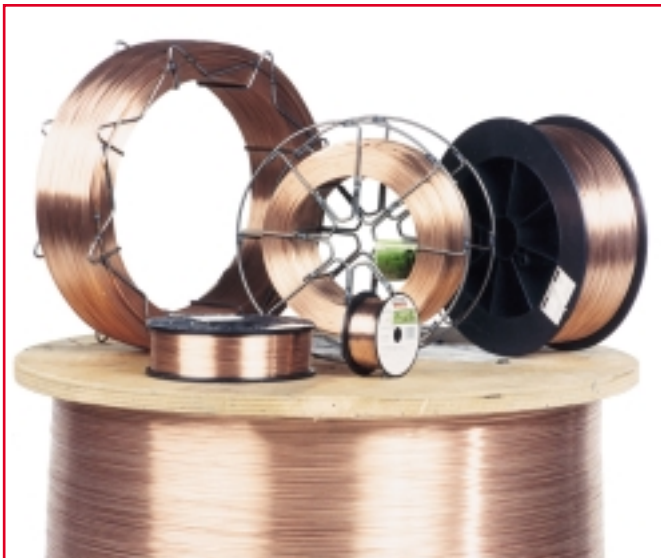
Adapts 60 lb. (27.2 kg) coils of wire to 2" (51mm) spindle.  
Order K1504-1.



## Ordering Information

### L-50

Packaging Size	L-50					
	.030 (0.8)	.035 (0.9)	.040 (1.0)	.045 (1.1)	.052 (1.3)	1/16 (1.6)
<b>Readi-Reel</b> 30 lb. (14 kg) 60 lb. (27 kg)	ED011299	ED011302		ED011307		
		ED014426	EDS01409	ED014427		
<b>Plastic Spool</b> 30 lb. (14 kg)	ED016102	ED016097	EDS01064	ED016098		
<b>Fiber Spool</b> 44 lb. (20 kg) 60 lb. (27 kg)	EDS01055	ED021268	EDS01047	ED021270	ED021272	
		ED021269	EDS01065	ED021271	ED021273	
<b>Coil</b> 60 lb. (27 kg)		ED011301	EDS01408	ED011306	ED011311	ED011317
<b>Accu-Trak Drum</b> 500 lb. (227 kg) 900 lb. (409 kg)	EDS01401	ED021052		ED020526	ED020257	
		ED027365		ED027366		
<b>Accu-Trak Reel</b> 1000 lb. (454 kg)		ED021361		ED020524	ED020525	EDS01414
<b>Speed Feed Drum</b> 600 lb. (272 kg)						ED011316
<b>Speed Feed Reel</b> 300 lb. (136 kg) 1000 lb. (454 kg)		EDS11303		EDS11308	EDS11312	EDS11318
		ED011647		ED011648	ED011649	ED011650
<b>Vertical Reel</b> 1000 lb. (454 kg)		EDS25922		EDS25923	EDS25924	ED025925



### SMALL PACKAGING PALLET WEIGHTS

Packaging Type	Package Weight		Pallet Weight	
	lbs	(kg)	lbs	(kg)
Readi-Reel	30	(14)	2430	(1105)
Readi-Reel	60	(27)	3240	(1473)
Fiber Spool	44	(20)	3564	(1620)
Fiber Spool	60	(27)	3240	(1473)
Plastic Spool	30	(14)	2430	(1105)
Eco Spool	30	(14)	2430	(1105)
Eco Spool	44	(20)	3564	(1620)
Coil	60	(27)	3240	(1473)

## Ordering Information

### S3, L-52, L-54

Packaging Size	S3				L-52		L-54		
	.035 (0.9)	.045 (1.1)	.052 (1.3)	1/16 (1.6)	.035 (0.9)	.045 (1.1)	.035 (0.9)	.045 (1.1)	.052 (1.3)
<b>Readi-Reel</b> 30 lb. (14 kg) 60 lb. (27 kg)							EDS01425		
<b>Plastic Spool</b> 30 lb. (14 kg)					EDS25043 EDS25044				
<b>Fiber Spool</b> 44 lb. (20 kg) 60 lb. (27 kg)	ED028621	ED028622	ED028623		EDS25045	EDS25046	ED021127	ED021118	ED021120
<b>Coil</b> 60 lb. (27 kg)							ED021123 ED021124		
<b>Accu-Trak Drum</b> 500 lb. (227 kg) 900 lb. (409 kg)	ED028630	ED028631	ED028632						
<b>Accu-Trak Reel</b> 1000 lb. (454 kg)	ED028627	ED028628	ED028629	ED028634			EDS01619		
<b>Speed Feed Drum</b> 600 lb. (272 kg)									
<b>Speed Feed Reel</b> 300 lb. (136 kg) 1000 lb. (454 kg)	ED028624	ED028625	ED028626	ED028633			ED021132		
<b>Vertical Reel</b> 1000 lb. (454 kg)									

### LA-75, LA-90, LA-100

Packaging Size	LA-75		LA-90				LA-100	
	.035 (0.9)	.045 (1.1)	.035 (0.9)	.045 (1.1)	.052 (1.3)	1/16 (1.6)	.045 (1.1)	1/16 (1.6)
<b>Readi-Reel</b> 30 lb. (14 kg)	EDS15528	EDS15529	ED015337	ED015338			ED010994	
<b>Fiber Spool</b> 60 lb. (27 kg)			EDS01380					
<b>Coil</b> 60 lb. (27 kg)		EDS15601	ED011088	ED014779		ED013999	ED010993	ED010996
<b>Speed Feed Reel</b> 1000 lb. (454 kg)			ED014902	ED14828	EDS01383			
<b>Accu-Trak Drum</b> 500 lb. (227 kg)			EDS01372	EDS01378			EDS01162	

# Ordering Information

## L-56 and S6

Packaging Size	L-56							S6			
	.025 (0.6)	.030 (0.8)	.035 (0.9)	.040 (1.0)	.045 (1.1)	.052 (1.3)	1/16 (1.6)	.035 (0.9)	.045 (1.1)	.052 (1.3)	1/16 (1.6)
<b>Readi-Reel</b> 30 lb. (14 kg) 60 lb. (27 kg)			ED011656	EDS01620	ED011660						
			ED011428		ED014429	ED014916					
<b>Plastic Spool</b> 2 lb. (0.9 kg) 12.5 lb. (6 kg) 30 lb. (14 kg)	ED027640	ED028674	ED028675								
	ED015790	ED023334	ED028676								
	EDS01436	ED016104	ED016099	EDS01094	ED016100						
<b>Fiber Spool</b> 44 lb. (20 kg) 60 lb. (27 kg)			ED021274		ED021276	ED021278		ED028635	ED028636	ED028637	
			ED021275		ED021277	ED021279					
<b>Eco Spool</b> 30 lb. (14 kg) 44 lb. (20 kg)			ED026900		ED026901						
			ED025945		ED025946						
<b>Coil</b> 60 lb. (27 kg)			ED011655		ED011659	ED011663	ED011666				
<b>Accu-Trak Drum</b> 500 lb. (227 kg) 900 lb. (409 kg)			ED021056		ED020532	ED020533	EDS01450				
			ED027367		ED027368			ED028646	ED028647	ED028648	
<b>Accu-Trak Reel</b> 1000 lb. (454 kg)			ED021362		ED020530	ED020531		ED028642	ED028643	ED028644	ED028645
<b>Speed Feed Drum</b> 600 lb. (272 kg)							ED011665				
<b>Speed Feed Reel</b> 300 lb. (136 kg) 1000 lb. (454 kg)			EDS11657		EDS11661						
			ED011734		ED011735	ED011736	ED011737	ED028638	ED028639	ED028640	ED028641
<b>Vertical Reel</b> 1000 lb. (454 kg)			EDS25931		EDS25932	EDS25933	EDS25934				

### 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 customer's 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 been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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