



Exclusive Product Line that Combines
the Best in Toughness and Wear Resistance
for the Rail Industry

ManTrak 2



- High deposition FCAW designed to work harden rapidly in service
- Exceptional toughness and work hardening properties
- Provides superior resistance to the combined stress of compression and severe impact

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High deposition Flux Cored Open Arc Wire (FCAW) designed to work harden rapidly in service and to a higher hardness without risk of cracking.

Deposits offer exceptional toughness and work hardening properties. Multi-layered deposits of this high-strength chrome manganese steel wire have a high resistance to the combined stress of compression and severe impact.

Especially suitable for high tonnage frogs that require longer service life.

TECHNICAL DATA

Typical Values	
Hardness:	AD: 20-25 HRC WH: 45-50 HRC
Tensile Strength:	130,000 psi (896 N/mm ²)
Elongation:	35%
Current polarity:	DC Reverse

DIAMETER	AMPS	VOLTS
1/16" (1.6 mm)	140-220	21-26
5/64" (2.0 mm)	175-280	24-28

PROCEDURE FOR USE

PREPARATION:

Clean weld area. Remove any loose or fatigued metal by using ChamferTrode® (AC/DC) or by grinding. Preheat is not normally recommended.

TECHNIQUE:

To maintain low heat input, "skip" welding or "back-step" welding techniques could be used. May be used in the horizontal or flat position.

POST-WELDING:

Allow parts to cool slowly.

TYPICAL APPLICATIONS

For manganese steels where resistance to severe impact, shock and hammering is required.

Ideal for for high tonnage frogs that require longer service life.



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