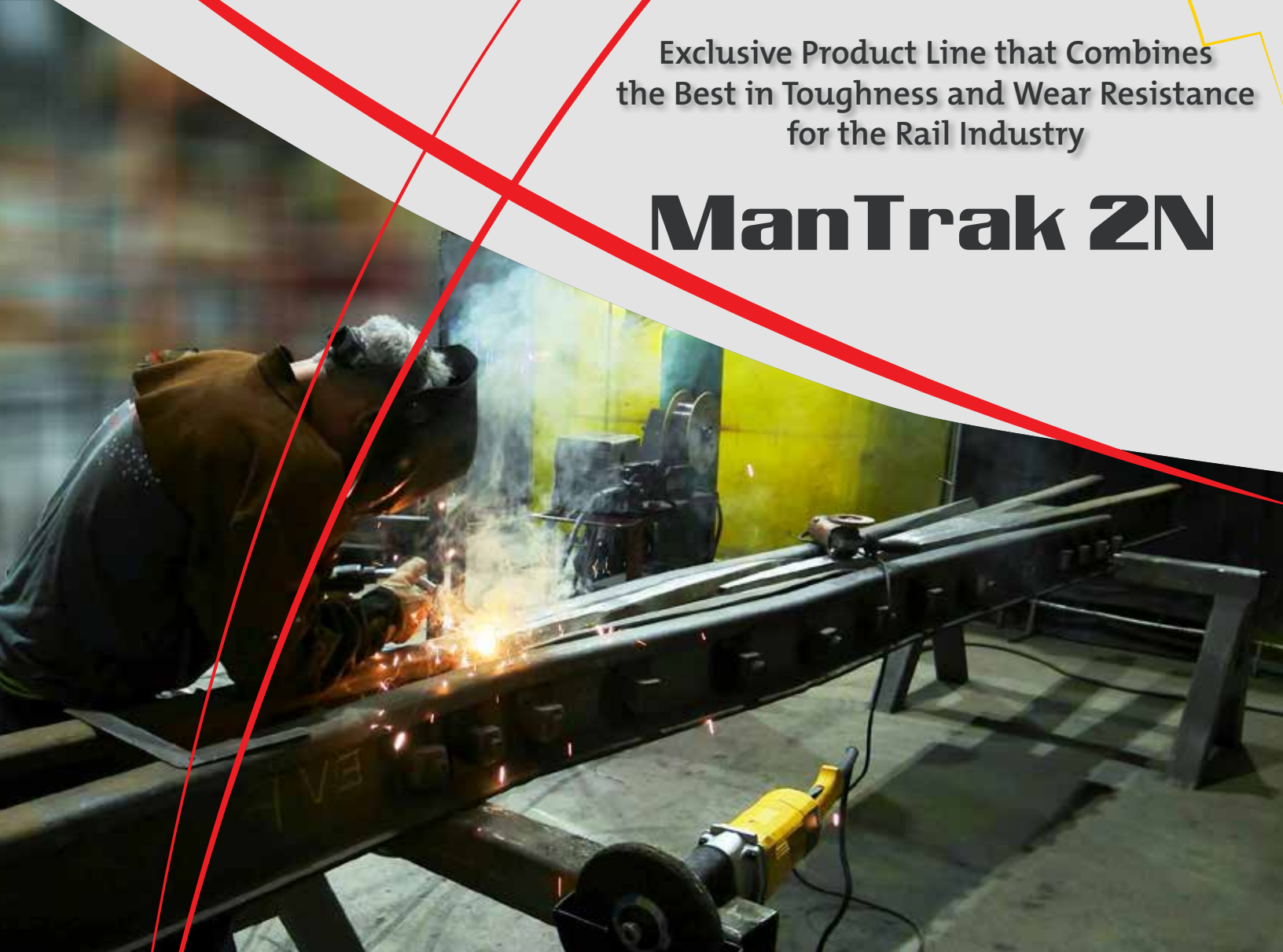




Exclusive Product Line that Combines  
the Best in Toughness and Wear Resistance  
for the Rail Industry

# ManTrak 2N



- High deposition FCAW for build-up and restoration of manganese steel track components
- Designed for welding at lower amperages and to work harden rapidly
- Provides superior crack resistance and improved resistance to impact induced spalling

# ManTrak 2N

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

It is similar to ManTrak #2, but designed to weld at lower amperages to prevent overheating of frog switch points and wings.

It provides excellent work-hardening properties on 12-14% Manganese steels.

This alloy has superior crack resistance as well as improved resistance to impact-induced spalling.

## TECHNICAL DATA

Typical Values	
Hardness:	AD: 20-25 HRC WH: 45-50 HRC
Tensile Strength:	145,000 psi (1000 N/mm <sup>2</sup> )
Elongation:	30%
Current polarity:	DC Reverse

DIAMETER	AMPS	VOLTS
1/16" (1.6 mm)	140-250	22-26
5/64" (2.0 mm)	170-250	24-28

## PROCEDURE FOR USE

### PREPARATION:

Clean weld area. Remove cracked and fatigued metal, including prior weld deposits 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

Designed for frogs, switches, stock rail and for Manganese steels where resistance to severe impact, shock and hammering is required.



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