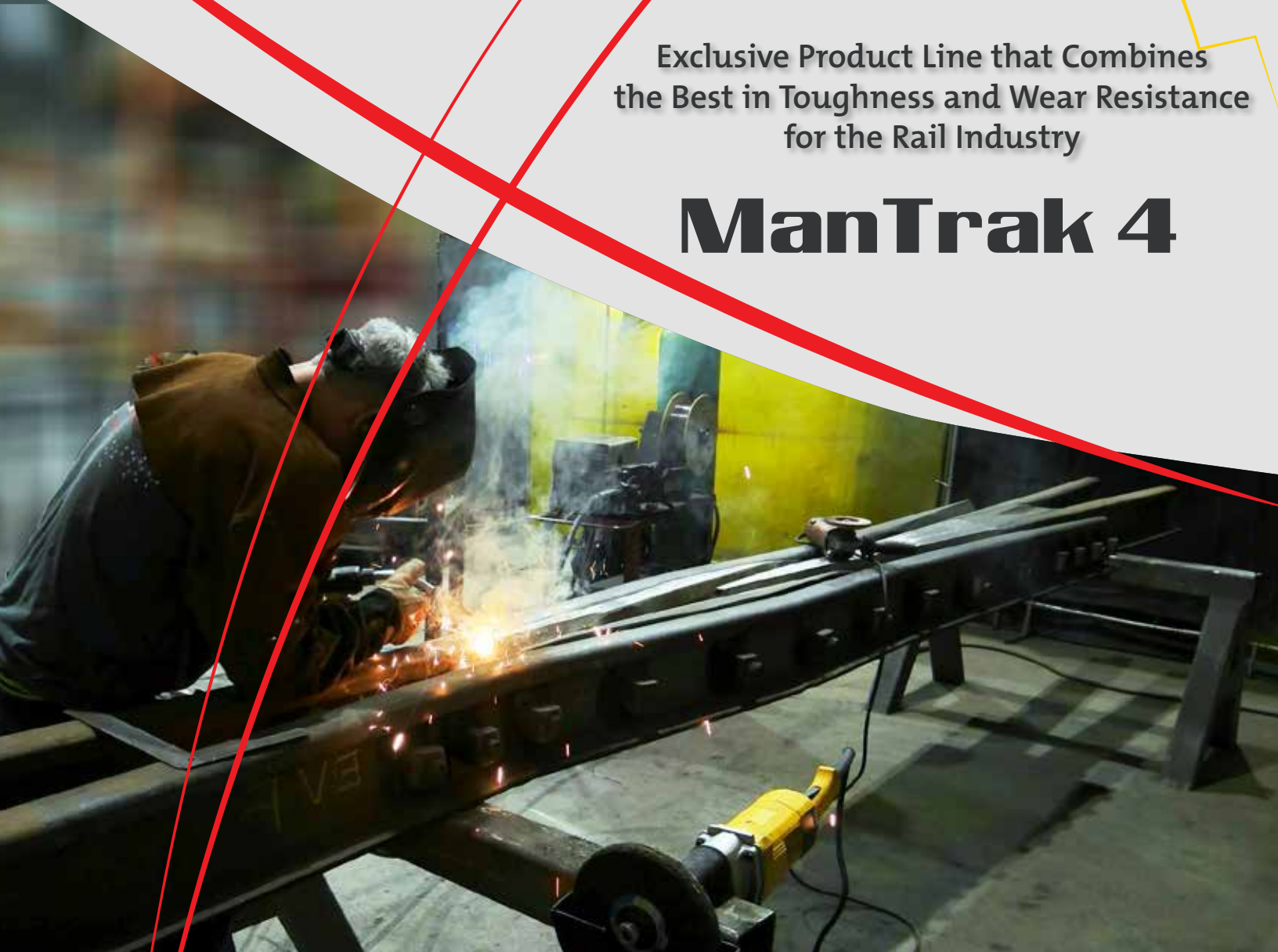




Exclusive Product Line that Combines
the Best in Toughness and Wear Resistance
for the Rail Industry

ManTrak 4



- High deposition FCAW for build-up and restoration of manganese steel track components
- Designed to provide maximum resistance to impact shock and hammering
- Enhanced microstructure minimizes carbide precipitation at the grain boundaries

ManTrak 4

High deposition Flux Cored Open Arc Wire (FCAW) designed to provide maximum resistance to impact, shock and hammering.

Stabilizers have been added to minimize carbide precipitation at the grain boundaries.

TECHNICAL DATA

Typical Values	
Hardness:	AD: 20-27 HRC WH: 45-50 HRC
Tensile Strength:	126,000 psi (869 N/mm ²)
Elongation:	32%
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.

