



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

# TufTrak 1



- All position electrode for build-up and overlay of carbon steel track components
- Provides a high level of toughness and fatigue resistance
- Deposits resist mild abrasion and severe impact

# TufTrak 1

All position electrode used for build-up and overlay on carbon steel railroad track and track parts. It resists mild abrasion and severe impact.

Formulated to deposit weld metal with a high level of toughness and fatigue resistance, it exhibits low fuming and low spatter when welding, with excellent slag removal properties. A mid-range hardness helps maintain post-weld deposit profiles.

## TECHNICAL DATA

Typical Values	
Hardness:	35-40 HRC
Tensile Strength:	140,000 psi (965 N/mm <sup>2</sup> )
Current polarity:	AC/DC Reverse

DIAMETER	AMPS
1/8" (3.2 mm)	100-150
5/32" (4.0 mm)	150-200
3/16" (4.8mm)	225-275

## PROCEDURE FOR USE

### PREPARATION:

Clean weld area. Preheat according to the type of rail: 700°F (375°C) for standard grade; 750°F (400°C) for chrome rail; 800°F (430°C) for low alloy head hardened rail.

### TECHNIQUE:

Maintain interpass temperatures to assure consistent weld metal hardness.

Use stringer beads or slight weave while holding a short to medium arc. Chip slag and wire brush between passes.

### POST-WELDING:

Post-heat according to the type of rail:

- 1200°F (650°C) for chrome alloy and low alloy head hardened rail;
- 1100°F (600°C) for standard grade.

## TYPICAL APPLICATIONS

Ideal for harder carbon steel rails, switch points, switch point protectors and repair of engine burns and many other railroad industry hardfacing applications.



**Eutectic Corporation:**  
N94 W14355 Garwin Mace Dr.  
Menomonee Falls WI, 53051 USA  
+1 800. 558. 8524 • eutectic.com

**Eutectic Canada:**  
428, rue Aimé-Vincent, Vaudreuil-Dorion,  
Québec J7V 5V5 Canada  
+1 800. 361. 9439 • eutectic.ca



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