Castolin Eutectic®
Eutectic Castolin

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

TufTrak 2

- High deposition fluxed cored wire for build-up and overlay on carbon steels
- Deposits are tough and resistant to heavy shock loading and ponding
- Excellent weldability and machinability

TufTrak 2

High deposition Flux Cored Open Arc Wire (FCAW) for build-up and overlay on carbon steels. Deposits are especially tough and resistant to heavy shock loading and pounding.

It has exceptional toughness and impact resistance with superior crack resistance.

Weldability is excellent and weld deposits have improved machinability.

TECHNICAL DATA

Typical Values	
Hardness:	35-40 HRC
Tensile Strength:	120,000 psi (828 N/mm^2)
Current polarity:	DC Reverse

DIAMETER	AMPS	VOLTS
5/64” (2.0 mm)	170-250	24-28

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 crescent weave with a 1-2” (25-50mm) stickout.

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 all carbon steel castings, stock rail, rigid rails frogs, wheel transfer sections and many other railroad industry applications.

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08-2022