



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

# TufTrak 4



- All position electrode for build-up and overlay of carbon steel track components
- Excellent toughness helps to maintain rail-to-wheel contact and minimize “burns”
- Deposits are dense, free from porosity and are readily machined or shaped to profile

# TufTrak 4

All position electrode for heavy build-up and cushioning on carbon steel parts subjected to impact and compression.

Weld deposits are dense, free from porosity and readily machined or shaped to profile.

Excellent toughness helps to maintain rail-to-wheel contact and minimize “burns”.

## TECHNICAL DATA

Typical Values	
Hardness:	31-35 HRC
Tensile Strength:	115,000 psi (793 N/mm <sup>2</sup> )
Current polarity:	AC/DC Reverse

DIAMETER	AMPS
1/8" (3.2 mm)	105-160
5/32" (4.0 mm)	150-210
3/16" (4.8mm)	200-260
1/4" (6.4 mm)	240-310

## 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

Applications include carbon steel parts, frogs, switches and stock rail. It is also suitable for re-building hammers, wobblers, sprockets, and some spur gears.

