



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

TufTrak 5



- High deposition fluxed cored wire for build-up and overlay on carbon steels
- Provides resistance to high compression wear along with superior impact properties
- Easy slag removal and minimum fuming

TufTrak 5

High deposition wire for build-up and cushioning on carbon steel parts subjected to impact and compression.

This Flux Cored Open Arc Wire (FCAW) has an optimum range of mechanical properties. Resistance to high compression wear is excellent along with superior impact properties.

Easy slag removal and minimum fuming make this wire welder-friendly.

TECHNICAL DATA

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

DIAMETER	AMPS	VOLTS
1/16" (1.6 mm)	140-220	23-30
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 ChamferTrobe (AC/DC) or by grinding. 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

Designed for hardfacing carbon steel parts, frogs, switches and stock rail.



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