



## All Position Electrode ManTrak #1N

Build-up, Overlay & Joining on Mn Steels

**DESCRIPTION:** ManTrak #1N is a versatile all position nickel-manganese electrode used for heavy build-up, overlay and joining on Manganese steel trackwork. It is highly resistant to fatigue-related compression and to battering wear and exhibits excellent weldability with minimum fuming and little, if any, spatter.

**TYPICAL APPLICATIONS:** Applications include Manganese railroad frogs, frog inserts and crossings.

### TECHNICAL DATA

Typical Hardness:	As Deposited, 85-95 HRB Work hardened, 45-50 HRC
Typical Tensile Strength:	115,000 psi (793 N/mm <sup>2</sup> )
Typical Elongation:	45%
Polarity:	AC/DC Reverse

**PREPARATION:** Clean weld area. Remove cracked and fatigued metal, including prior weld deposits by using ChamferTrode® (AC/DC) or by grinding. Surfaces should be cleaned of all grease, dirt and scale.

**TECHNIQUE:** To maintain low heat input, “skip” welding or “back-step” welding techniques could be used. Craters should be back-whipped.

**POST WELDING:** Allow parts to cool slowly.

Diameter : (in)	1/8”	5/32”	3/16”	1/4”
(mm)	3.2	4.0	4.8	6.4
Amperage Range:	100 - 150	150 – 200	200 – 250	240 – 300

**Statement of Liability:** Due to variations inherent in specific applications, the technical information contained herein, including any information as to suggested product applications or results, is presented without representation or warranty, expressed or implied. Without limitation, there are no warranties of merchantability or of fitness for a particular purpose. Each process and application must be fully evaluated by the user in all respects, including suitability, compliance with applicable law and non-infringement of the rights of others, and Eutectic Corporation and its affiliates shall have no liability in respect thereof.

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