



High Deposition Flux Cored Wire for Mn Steels

ManTrak #2N

Designed for Welding at Lower Amperages

DESCRIPTION: ManTrak #2N is a high deposition Flux Cored Open Arc Wire (FCAW) designed to work harden rapidly, in-service and to a higher hardness without risk of cracking. It is similar to ManTrak #2, but designed to weld at lower amperages to prevent overheating of frog switch points and wings. It provides excellent work-hardening properties on 12-14% Manganese steels. This alloy has superior crack resistance as well as improved resistance to impact-induced spalling.

TYPICAL APPLICATIONS: Designed for frogs, switches, stock rail and for Manganese steels where resistance to severe impact, shock and hammering is required.

TECHNICAL DATA

Typical Hardness:	As Deposited, 20-25 HRC Work hardened, 45-50 HRC
Typical Tensile Strength:	145,000 psi (1000 N/mm ²)
Typical Elongation:	30%
Polarity:	DC Reverse

PREPARATION: Clean weld area. Remove cracked and fatigued metal, including prior weld deposits by using ChamferTrode® (AC/DC) or by grinding. Preheat is not normally recommended.

TECHNIQUE: To maintain low heat input, “skip” welding or “back-step” welding techniques could be used. May be used in the horizontal or flat position.

POST WELDING: Allow parts to cool slowly.

Diameter : (in)	1/16”	5/64”
(mm)	1.6	2.0
Amperage Range:	140 - 250	170 – 250
Voltage:	22 - 26	24 - 28

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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