



High Deposition Flux Cored Wire

ManTrak #4

Maximum Resistance to Impact on Mn Steels

DESCRIPTION: ManTrak #4 is a high deposition Flux Cored Open Arc Wire (FCAW) providing maximum resistance to impact, shock and hammering. Stabilizers have been added to minimize carbide precipitation at the grain boundaries.

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, 85-95 HRB Work hardened, 45-50 HRC
Typical Tensile Strength:	126,000 psi (869 N/mm ²)
Typical Elongation:	32%
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

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