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

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Typical Hardness:</td>
<td>As Deposited, 85-95 HRB</td>
</tr>
<tr>
<td>Work hardened</td>
<td>45-50 HRC</td>
</tr>
<tr>
<td>Typical Tensile Strength:</td>
<td>126,000 psi (869 N/mm²)</td>
</tr>
<tr>
<td>Typical Elongation:</td>
<td>32%</td>
</tr>
<tr>
<td>Polarity:</td>
<td>DC Reverse</td>
</tr>
</tbody>
</table>

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.

<table>
<thead>
<tr>
<th>Diameter (in)</th>
<th>1/16”</th>
<th>5/64”</th>
</tr>
</thead>
<tbody>
<tr>
<td>(mm)</td>
<td>1.6</td>
<td>2.0</td>
</tr>
<tr>
<td>Amperage Range</td>
<td>140 – 250</td>
<td>170 – 250</td>
</tr>
<tr>
<td>Voltage</td>
<td>22 - 26</td>
<td>24 - 28</td>
</tr>
</tbody>
</table>

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