



All Position Electrode

TufTrak #1

Build-up and Overlay on Carbon Steels

DESCRIPTION: TufTrak #1 is an all position electrode used for build-up and overlay on carbon steel railroad track and track parts. It resists mild abrasion and severe impact. Formulated to deposit weld metal with a high level of toughness and fatigue resistance, it exhibits low fuming and low spatter when welding, with excellent slag removal properties. A mid-range hardness helps maintain post-weld deposit profiles.

TYPICAL APPLICATIONS: It is ideal for harder Carbon steel rails, switch points, switch point protectors and repair of engine burns and many other railroad industry hardfacing applications.

TECHNICAL DATA

Typical Hardness:	35-40 HRC
Typical Tensile Strength:	140,000 psi (965 N/mm ²)
Polarity:	AC/DC Reverse

PREPARATION: Clean weld area. 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 stringer beads or slight weave while holding a short to medium arc. Chip slag and wire brush between passes.

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.

Diameter : (in)	1/8"	5/32"	3/16"
(mm)	3.2	4.0	4.8
Amperage Range:	100-150	150-200	225-275

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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