



Rapid Deposition Fluxed Cored Wire

TufTrak #2

Build-up and Overlay on Carbon Steels

DESCRIPTION: TufTrak #2 is a rapid deposition Flux Cored Open Arc Wire (FCAW) for build-up and overlay on carbon steels. Deposits are especially tough and resistant to heavy shock loading and pounding. It has exceptional toughness and impact resistance with superior crack resistance. Weldability is excellent and weld deposits have improved machinability.

TYPICAL APPLICATIONS: Ideal for all carbon steel castings, stock rail, rigid rails frogs, wheel transfer sections and many other railroad industry applications.

TECHNICAL DATA

Typical Hardness:	35-40 HRC
Typical Tensile Strength:	120,000 psi (828 N/mm ²)
Polarity:	DC Reverse
Voltage:	24-28

PREPARATION: Clean weld area. Remove cracked and fatigued metal, including prior weld deposits by using ChamferTrode (AC/DC) or by grinding. 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 crescent weave with a 1-2" (25-50mm) stickout.

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)	5/64"
(mm)	2.0
Amperage Range:	170-250

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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