



All Position Electrode TufTrak #4

Build-up and Overlay on Carbon Steels

DESCRIPTION: TufTrak #4 is an all position electrode for heavy build-up and cushioning on carbon steel parts subjected to impact and compression. Weld deposits are dense, free from porosity and readily machined or shaped to profile. Excellent toughness helps to maintain rail-to-wheel contact and minimize “burns”.

TYPICAL APPLICATIONS: Applications include carbon steel parts, frogs, switches and stock rail. It is also suitable for re-building hammers, wobblers, sprockets, and some spur gears.

TECHNICAL DATA

Typical Hardness:	31-35 HRC
Typical Tensile Strength:	115,000 psi (793 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"	1/4"
(mm)	3.2	4.0	4.8	6.4
Amperage Range:	105-160	150-210	200-260	240-310

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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