



High Deposition Flux Cored Wire

TufTrak #5

Build-up and Overlay on Carbon Steels

DESCRIPTION: TufTrak #5 a high deposition wire for build-up and cushioning on carbon steel parts subjected to impact and compression. This Flux Cored Open Arc Wire (FCAW) has an optimum range of mechanical properties. Resistance to high compression wear is excellent along with superior impact properties. Easy slag removal and minimum fuming make this wire welder-friendly.

TYPICAL APPLICATIONS: Designed for hardfacing carbon steel parts, frogs, switches and stock rail.

TECHNICAL DATA

Typical Hardness:	31-35 HRC
Typical Tensile Strength:	115,000 psi (793 N/mm ²)
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 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" (2.5-5cm) 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 grades.

Diameter : (in)	1/16"	5/64"
(mm)	1.6	2.0
Amperage Range:	140 - 220	170 - 250
Voltage:	23 - 30	24 - 28

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.

Eutectic Corporation

N94 W14355 Garwin Mace Dr.
Menomonee Falls, WI 53051

1-800-558-8524