

DESCRIPTION

Trackwear is a high strength austenitic manganese steel alloy developed for the build-up of manganese steel castings, particularly parts subject to heavy battering loads such as railroad frogs and crossings. Deposits have a high initial yield strength and hardness and work harden quickly with minimum flow and rollover. Trackwear is compatible with any other standard manganese steel welding material that may have been applied previously. On railroad frogs, Trackwear is often used as a 2 layer topping on a build-up of Stoody Nicromang. Deposits do not respond to heat treatment. It is not recommended for build-up of carbon steel.

TYPICAL APPLICATIONS

Typical applications include:

- Standard Manganese Steel Alloy Casings
- Nickel Manganese Steel Alloy Castings
- Molybdenum Manganese Steel Castings
- Railroad Frogs
- Steel Mill Rolls
- Crusher Rolls and Jaws
- Dipper Fronts and Teeth
- Shovel Pads

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Low
Impact Resistance	Very High
Deposit Layers	Multiple
Tensile Strength	128,000 psi
Yield Strength	85,000 psi
Elongation	25%
Hardness, As Deposited	235 BHN
Hardness, Work Hardened	500 BHN
Magnetic	No
Machinability	Poor

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	90 – 150	100 – 160
Position	Flat	Flat
Diameter, In. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCRP	140 – 230	200 – 300
Position	Flat	Flat

ALLOY TYPE

High Strength Austenitic Manganese Steel

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8 (3.2mm)	10# Box	48700810
5/32" (4.0mm)	10# Box	48701010
5/32" (4.0mm)	60# Bulk Pak	48701050
3/16" (4.8mm)	10# Box	48701210
3/16" (4.8mm)	60# Bulk Pak	48701250
1/4" (6.4mm)	10# Box	48701650
1/4" (6.4mm)	60# Bulk Pak	48701650