

**GENERAL CHARACTERISTICS:**

ARCTEC® RAILTEC® is an economical electrode for general build up and overlay applications. The weld deposit is dense and porosity free and has good resistance to impact. The special coating makes it possible to use this electrode in all positions. Deposit is machinable.

APPLICATIONS:

ARCTEC® RAILTEC® is suitable for build up on gears, couplings, shafts, tractor rollers and idlers. Ideal for rebuilding worn surfaces of carbon steels such as rails, railway frogs and switches and other surfaces subject to severe impact loads. Excellent for build up on carbon steel parts where machinability must be retained and as a cushion layer for hard facing.

WELDING PROCEDURE:

Remove grease, oil and other contaminants prior to welding. With electrode vertical to work-piece maintain a short to medium arc-length. A weaving technique may be used where desired.

MECHANICAL PROPERTIES:

Hardness
275-325 HB
26-35 HRC

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	110-130	140-160	170-190	190-230

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