



To Order Call: 1-859-525-6385

RAILBUILD 540 Flux-Coated Stick Electrode

RAILBUILD 540 Flux-Coated Electrode is designed specifically for build-up of rail ends, switch points, carbon steel frogs and engine



burns. The special alloying resists high-speed impact and abrasion. The smooth running characteristics allows even the inexperienced welder to produce a quality repair. Deposits can be built up to heavy thicknesses without the danger of cracking.

PROCEDURES:

Remove chipped, cracked and fatigued material by grinding. **DO NOT USE AIR CARBON ARC GOUGING ON CARBON STEEL.** Rail and rail components should be pre-heated to 700 degrees Fahrenheit. Interpass temperature should be maintained at 700 degrees Fahrenheit. Post heat to 1000 degrees Fahrenheit.

TECHNICAL DATA:

DC Reverse Polarity
Hardness (first pass)40-42 Rc
Hardness (subsequent passes)36-38 Rc

WELDING PARAMETERS:

1/8"	110-130 Amps
5/32"	140-160 Amps
3/16"	170-200 Amps
1/4"	210-230 Amps

ORDERING INFORMATION:

540-3.....	1/8" Dia, 40lb Box
540-4.....	5/32" Dia, 40lb Box
540-5.....	3/16" Dia, 40lb Box
540-6.....	1/4" Dia, 40lb Box