



## FROGBUILD 570 Flux-Coated Stick Electrode



FROGBUILD 570 Flux-Coated Wire is a proven solution for the repair and build-up of manganese castings. The alloy content produces a tough

ductile deposit, which will withstand the high-speed impact and heavy tonnage of today's railroads. Proven effective in reducing untimely failures due to separations and excessive wear.

### PROCEDURES:

Remove all work hardened and fatigued material by grinding or air carbon arc gouging. Deposit should be made with a slight weave or stringer bead making sure each pass is tied into the one adjacent by a 40% overlap. Bead width should not exceed 5/8". Do not preheat manganese. The base metal temperature must not exceed 500 degrees F. Interpass temperature should not be above 350 degrees F.

### TECHNICAL DATA:

DC Reverse Polarity	
Tensile Strength .....	124,000 PSI
Yield Strength .....	90,000 PSI
Hardness (as deposited).....	18-24 Rc
Hardness (work hardened) .....	50-55 Rc

### WELDING PARAMETERS:

5/32"	150-170 Amps
3/16"	180-200 Amps
1/4"	210-230 Amps

### ORDERING INFORMATION:

570-4 .....	5/32" Dia, 40lb Box
570-5 .....	3/16" Dia, 40lb Box
570-6 .....	1/4" Dia, 40lb Box