



To Order Call: 1-859-525-6385

RAILBUILD 540W Flux-Cored Wire

RAILBUILD 540W Flux-Cored Wire 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. Bead width should be 3/4"-1" wide to maintain temperature. 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:

1/16"	210-250 Amps	27-29 Volts
5/64"	250-300 Amps	27-29 Volts

ORDERING INFORMATION:

540W-1S..... 1/16" Dia, 30lb Spools
540W-5S..... 5/64" Dia, 30lb Spools
540W-5S10..... 5/64" Dia, 10lb Spools