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## FROGBUILD 575W and 575W-M Flux-Cored Wire

FROGBUILD 575W and 575W-M (modified) Flux-Cored Wire is an improved solution for the repair and build-up of manganese castings. It produces a clean weld deposits with improved slag release and less smoke. The higher alloy content produces a tougher deposit which is more resistant to impact and compression, resulting in less flow and extended life.



- Modified was created to have better slag relief.

### 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:

5/64"                      260-300 Amps                      28-29 Volts

### ORDERING INFORMATION:

575W-5S ..... 5/64" Dia, 30lb Spools  
 575W-5S10 ..... 5/64" Dia, 10lb Spools