



## TRACK-WELD 910 Flux-Coated Stick Electrode



TRACK-WELD 910 Flux-Coated Electrode is a premium high strength electrode to be used at the bottom of cracks and as a buffer layer under FROG-

BUILD where you have severe impact and compression. It is designed to be used to build-up and repair frogs and track. Also excellent for joining high alloy steel to low alloy steel or unalloyed steel. The deep penetrating characteristics allow it to tie in and fill casting defects and sand pockets.

### PROCEDURES:

Remove all cracks by grinding or air carbon arc gouging. Defect area must be prepared to ensure there is room to weave the electrode for 100% penetration and complete tie in to the base metal. Maintain approximately a 30-degree angle on the electrode and hold a short arc.

### TECHNICAL DATA:

DC Reverse Polarity	
Tensile Strength .....	106,000 PSI
Yield Strength .....	62,000 PSI
Elongation.....	40%
Hardness (as welded) .....	10 Rc
Hardness (work hardened) .....	45 Rc

### WELDING PARAMETERS:

5/32"	120-165 Amps
3/16"	140-190 Amps

### ORDERING INFORMATION:

910-4 .....	5/32" Dia, 40lb Box
910-5 .....	3/16" Dia, 40lb Box