

Lincore[®] FROG MANG[®]

Key Features

- Self-shielded open arc cored wire
- High alloy austenitic manganese deposit
- Unlimited layers with proper preheat and interpass temperatures and procedures

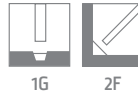
Typical Applications

- Repair of manganese frogs and crossing diamonds in the railroad industry

Conformances

AS/NZS 2576: 1220 B7*
(nearest equivalent)

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.6	ED026106	Steel Spool 11.3kg

Mechanical Properties

Rockwell - HRC	
As Welded	Work Hardened
20-30	40-50

Deposit Composition

	%C	%Mn	%Si	%Cr
Open Arc 6 Layers	<2	<30	<1	<10

Typical Operating Procedures

Diameter, Polarity, ESO	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.6 mm, DC+, 25 mm	200	27	220	3.0
	250	29	250	4.0
	325	32	300	5.3

NOTE: Remove all damaged and foreign material by the air-carbon arc gouging process and grinding. Make sure all defective metal is removed. In the event hairline cracks remain at flangeway depth, use a 3.2 mm diameter 308L electrode, to tie up these cracks and avoid hot cracking during the build-up process. As with all austenitic manganese welding products, interpass temperatures should be limited to 260°C maximum. A stringer bead, or at most, a slight weave is recommended to limit heat build-up. Excessive heat build-up causes manganese carbide precipitation which damages the toughness of austenitic manganese.