

HABCO FROGSPEC® (S)

HIGH ALLOY ELECTRODE FOR JOINING AND BUILD-UP OF AUSTENITIC MANGANESE STEELS AND CARBON PARTS. HIGH IMPACT AND ABRASION RESISTANCE

FEATURES

HABCO FROGSPEC® is a high nickel, chromium and manganese alloy used for building-up and joining manganese steel, low alloy quenched and tempered steel and all carbon steels. The high alloy deposits produced are extremely tough and shock resistant. Able to withstand extreme impact loading along with heavy abrasion, make **FROGSPEC® the toughest alloys of its class in the industry.** This electrode has excellent weldability in all positions and produces smooth even beads with very low spatter.

APPLICATIONS

Formulated for high impact environments such as rail frogs, switch points, crusher cones and rolls, hammers, grousers, bucket teeth and most other applications where manganese steels are used. **FROGSPEC®** is also an excellent base for harder wear-facing alloys.

INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. Gouge out or remove fatigued or checked metal using HABCO AIR-GOUGING CARBONS OR **RAILCUT MX 221**. Do not preheat. Maintain a medium short arc while keeping arc concentrated on the base metal. Avoid exceeding an inter-pass temperature of 500°F (260°C). Use water-cool method to keep manganese casting cool during welding process.

Tensile Strength: up to 125,000 Psi (88 kg/mm²)

Yield Strength: up to 92,000 Psi (65 kg/mm²)

Hardness as welded: 200 BNH

Work hardens to: 500 BNH

Current: AC or DC ±

Amperage:	110-135	125-190	150-250	210-350
Diameters: (in)	1/8	5/32	3/16	1/4
(mm)	3.25	4.0	5.0	6.0

• Available in **WIRE** form