

Postle Industries • Cleveland, OH USA • Telephone: 216-265-9000 • Fax: 216-265-9030

Postalloy® FrogTuff-FCO is a non-cracking high alloy austenitic manganese steel open-arc welding wire for joining, build-up or hardfacing. Produces high-strength, crack-free deposits that are tough, ductile and work-harden rapidly. The high yield strength reduces mushrooming from impact.



RR Frog

## Specifications

### Product Type

Wire: Flux-cored, Open-arc

### Weld Deposit Properties

Tensile Strength: 135,000psi

Yield Strength: 90,000psi

Elongation: 30%

Hardness as deposited: 20Rc

Work hardens in service to: 45-55Rc

Deposits can be flame-cut

Cannot be machined

## Applications

Railroad frogs

Manganese crossovers

## Postalloy® FrogTuff-FCO Welding Parameters

Current: Use DC Electrode Positive and Globular Metal Transfer

Diameter	Amps	Volts	Stick Out
1/16" (1.6mm)	150-300	23-28	1"-1¼"(25-32mm)
5/64" (2.0mm)	220-290	24-29	1"-1½"(25-38mm)

Welding Procedure

Please consult our

Alternative Electrode: Postalloy® FrogTuff

## Packaging Options

Diameter	Standard Packaging
1/16" (1.6mm)	25 lb spool
5/64" (2.0mm)	25 lb spool

Available Packaging
55 lb coil, 110 lb drum, 220 lb drum
55 lb coil, 110 lb drum, 220 lb drum