

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

POSTALLOY® RailTuff-FCO is a non-cracking strong, tough, low alloy open-arc build-up wire designed specifically for repair of carbon steel railroad track components. It is not intended for use on manganese steels. Provides excellent compressive strength and resistance to plastic deformation to maintain rail components. Weld deposits are exceptionally sound and dense, and heavy crack-free build-ups are possible.

Specifications

Product Type

Wire: Flux-cored, Open-arc

Weld Deposit Properties

Hardness: 35-40Rc

Maximum Deposit Thickness: Unlimited

Machinable with carbide tools

Applications

Railroad railends

Wheel burns

Wheel slip streaks

Carbon steel switch points

POSTALLOY® RailTuff-FCO Welding Parameters

Current: DC Reverse (DCEP)

Diameter	Amps	Volts	Stick Out
.045" (1.1mm)	125-225	20-26	1/2"-1"(12-25mm)
1/16" (1.6mm)	225-375	23-28	1"-1 1/4"(25-32mm)
5/64" (2.0mm)	220-290	24-29	1"-1 1/2"(25-38mm)

Welding Procedure

Please consult our Railroad Track Procedures Manual.

Alternative Electrode: Postalloy® RailTuff

Packaging Options

Diameter	Standard Packaging	Available Packaging
.045" (1.1mm)	25 lb spool	
1/16" (1.6mm)	25 lb spool	55 lb coil
5/64" (2.0mm)	25 lb spool	55 lb coil

