



## EAGLE 541 GL

Self shielded flux cored open arc wire for  
build-up on manganese steels.

### APPLICATIONS

Developed for build-up on manganese steels. This wire is commonly used for build-up on crusher rolls, manganese hammers, rail frogs, shovel pads, dredge pump parts crusher jaws dipper lids and manganese teeth.

### PROCEDURE

DC reverse polarity (+). Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use lowest effective amperage while maintaining a 1/2 to 3/4 inch stick out arc length making stringer beads to reduce heat input.

### GENERAL CHARACTERISTICS

The **EAGLE 541 GL** is a high chromium, high manganese alloy for build-up on manganese and carbon steel.

### TECHNICAL DATA

Hardness: (RC)	As deposited 20		
Hardness: (RC)	After work hardened 55		
Current:	DC Reverse (+)		
Sizes: (IN)		.045	1/16
(MM)		1.20	1.60
Amperage:		150 - 200	200 - 350
Voltage:		18 - 24	24 - 28

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