



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

Use DC Reverse [+] Polarity. Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use lowest effective ampreage 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** is a high chromium, nickel and managanese alloy for build-up on manganese and carbon steel.

TECHNICAL DATA

Current: DC Reverse [+] Polarity
Hardness: (RC) As Deposited 20
Hardness: (RC) After work hardened 55

WELDING PARAMETERS

Sizes: Inches	.045	1/16
mm	1.20	1.60
Volts:	18-24	24-28
Amperage:	150-200	200-350



≡ HIGH QUALITY WELDING PRODUCTS ≡

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