



# EAGLE 542 GL

*Self Shielded Flux Cored Open Arc Wire For Build-up  
and Joining of Manganese Steels*

## APPLICATIONS

Developed for build-up and joining of 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 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 542** is a high chromium, nickel and manganese alloy for joining and build-up on manganese and carbon steel. When used as a joining alloy it will produce extremely high tensile and porosity free deposits.

## TECHNICAL DATA

Current: DC Reverse [+] Polarity  
Tensile Strength: Approx. 115,000 - 119,000 psi  
Yield Strength: Approx. 70,000 - 76,000 psi  
Hardness: (RC) As Deposited 15 - 20  
Hardness: (RC) After work hardened 45 - 57

## WELDING PARAMETERS

Sizes: Inches	.045	1/16
mm	1.20	1.60
Volts:	18 - 24	24 - 28
Amperage:	180 - 225	225 - 350



≡ HIGH QUALITY WELDING PRODUCTS ≡

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