



EAGLE 614

Build-Up And Joining Of Manganese Steels

APPLICATIONS

Developed for build-up and joining of manganese steels. 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 AC or DC Reverse [+] Polarity. Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use lowest effective amperage while maintaining a medium arc length making stringer beads to reduce heat input.

GENERAL CHARACTERISTICS

The **EAGLE 614** is a high chromium, high manganese alloy for joining and build-up on manganese and carbon steel. When used as a joining alloy it will produce an extremely high tensile and porosity free deposit.

TECHNICAL DATA

Tip Colour: Beige
Hardness: (BH) As deposited 200
Hardness: (BH) After Work Harden 450

WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	1/8	5/32	3/16
	mm	3.25	4.00	5.00
Amperage:	110 - 130	140 - 180	190 - 240	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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