

APOLLO® - A

Shielded Metal Arc Welding
(SMAW-Stick)

For all low alloy, manganese, medium and high carbon steels.
Joining, build-up and wear surfacing.

ARC AC/DC

All Positions

FEATURES

- High strength 135,000 psi
- Shock and abrasion resistant
- Deposit 185 Brinell (11 RC)
- Work hardens to 55 RC
- Cuts easily with a torch
- Excellent for manganese steels
- No pre-heat or peening
- Coating not affected by moisture
- Good ductility
- Low friction surface

CHARACTERISTICS

APOLLO-A has been developed to produce the most crack resistant welds for use on heavy equipment. Impact loads on **APOLLO-A** deposits produce considerable work hardening to resist wear. In addition, this alloy has extraordinary strength combined with excellent ductility (30% elongation). It is superior for metal-to-metal wear applications.

When equipment is exposed to stress, shock, impact or abrasion, **APOLLO-A** is an ideal welding material. Outstanding results are found on all critical joints and when impact is present as in rails, frogs and cross overs. Use for manganese wear plates, buckets, crushers, hammers, dragline chains and pins.

When even more wear resistance is required, final passes should be made with our Olympia, Omega or Zeta hard face alloys.

APPLICATION

Remove all cracks or work hardened areas with Electra, or grind. Skip weld to avoid localized heat buildup. Weave no more than 2 to 3 times rod diameter.

TECHNICAL

Size and Amps AC/DC $\pm 20\%$

| | | | |
|---------|-------|-------|-------|
| Inches: | 1/8 | 5/32 | 3/16 |
| (mm): | (3.2) | (4.0) | (4.8) |

| | | | |
|-------|-----|-----|-----|
| Amps: | 120 | 160 | 200 |
|-------|-----|-----|-----|

With DC use reverse polarity. (DCEP)