

APOLLO® - FLUX CORE

Flux Core Arc Welding
(FCAW)

For welding low alloy and manganese steels, buildup,
wear surfacing and joining.

FEATURES

- 120,000 psi strength
- 40% elongation
- Non-magnetic deposit
- Minimum spatter loss
- Deposits can be flame cut
- Deposit thickness as required
- Crack resistant
- Austenite micro-structure
- Self shielded

CHARACTERISTICS

APOLLO FLUX CORE is a self shielded high manganese alloy wire. It is the welders choice for the tough buildup jobs, and for joining manganese to manganese or manganese to low alloy steels.

APOLLO FLUX CORE has an excellent mixture of chrome, nickel and manganese to produce a weld that combines strength, ductility and crack resistance while work hardening under impact.

APOLLO FLUX CORE runs with a minimum of spatter loss and has uniform slag coverage. The deposit can be flame cut, but it is difficult to machine. As deposited **APOLLO FLUX CORE** is 200 Brinell (15RC) and will work harden to 550 Brinell (55RC). This provides outstanding metal-to-metal wear resistance in many applications.

APOLLO FLUX CORE also produces an extremely sound base build-up for a hard overlay of **OMEGA FLUX CORE**. If gas shielding is available, **OLYMPIA FLUX CORE** or **ZETA FLUX CORE** would also be very suitable.

APPLICATION

Proven applications are railroad frogs and crossings, hammer mill hammers, impact bars, shovel pads, tooth buildup, crusher rolls, dredge pump parts, drag line chains and pins.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045"(1.2mm)	19-27	120-130	1/2"-1"
1/16"(1.6mm)	23-29	225-400	1"-1 1/2"

SHIELDING GAS OPTIONS: Self-Shielded

100% CO₂ will enhance weld bead, lessen spatter.