

# BRUTUS® - AAA

Shielded Metal Arc Welding  
(SMAW-Stick)

For dissimilar and all categories of steel-tool, high alloy, nickel alloy, stainless, manganese and cast steels.

## ARC AC/DC

All Positions

## FEATURES

- 35% elongation
- Strength 127,000 psi
- Easy strike and restrike
- No spatter/easy slag release
- Exceptionally smooth bead
- Spray-type arc with low heat
- Excellent undercoating for hardfacing
- Wear and shock resistant
- Ideal for dissimilar steels
- Ductile, crack resistant deposit
- Use for broken stud extraction (See broken stud extraction page 95)

## CHARACTERISTICS

**BRUTUS-AAA** has superior wear, shock and corrosion resistance and it can be used for joining dissimilar steels. In addition, **BRUTUS-AAA** has a special flux coating that gives it superior operating characteristics, allowing the welder to produce an unusually strong, smooth weld deposit with minimum effort.

**BRUTUS-AAA's** ease of application makes it especially suitable where precise weld control and appearance are important. Thin sections and delicate parts can be repaired easily. It gives excellent results on dies, tools, molds, gears and exposed food handling equipment. Its high strength and ductility make it useful in almost all repairs of similar or dissimilar steels.

## APPLICATION

Clean weld area. Bevel heavy sections. Preheat high alloys and heavy sections to 400°F (240°C). Use short arc. Tilt electrode 15° in direction of travel. For rapid filletting, increase amps and drag electrode at 45°. Remove slag between passes.

## TECHNICAL

Size and Amps AC/DC  $\pm 30\%$

|         |       |       |       |
|---------|-------|-------|-------|
| Inches: | 3/32  | 1/8   | 5/32  |
| (mm):   | (2.4) | (3.2) | (4.0) |

|       |    |    |     |
|-------|----|----|-----|
| Amps: | 65 | 95 | 120 |
|-------|----|----|-----|

With DC use reverse polarity. (DCEP)

