

OLYMPIA® - A

Shielded Metal Arc Welding
(SMAW-Stick)

For build up and hard facing carbon, low alloy high manganese steels and cast iron

OLYMPIA® - B

Shielded Metal Arc Welding
(SMAW-Stick)

For build up and hard facing carbon, low alloy, high manganese steels and cast iron

FEATURES O/A

- Deposited hardness 52/54 RC
- Resists abrasion
- Good impact resistance
- Work hardens to 60 RC
- Build up to 1/4"
- Excellent out of position
- Deposits may be hot forged

FEATURES O/B

- Deposits hardness to 66 RC
- Excellent abrasion resistance
- Mild impact resistance
- Forms ultra hard silicon carbide
- Good corrosion resistance
- Deposits contain chrome carbides

3

CHARACTERISTICS

OLYMPIA-A is a universal hard surfacing alloy which produces a self-hardening deposit that resists both severe abrasion and impact. In addition, the high deposition rate significantly lowers application cost.

In maintenance welding, **OLYMPIA-A** is outstanding for extending the service life of parts such as crusher rolls, hammers, cutter heads, shovel buckets and teeth, pump housings and impellers, tractor rails, pins, hooks, conveyors and screws, tampers and augers, etc.

OLYMPIA-B has been developed to prolong the service life of equipment exposed to severe abrasion, even when combined with mild impact. The ease of use, long wear and high deposition rate make **OLYMPIA-B** a most economical hard facing metal. Typical uses for **OLYMPIA-B** include bucket and loader lips, dredge pump impellers and housings, crusher jaws, screw conveyers, plow shoes, mixer chutes, and blades, etc.

APPLICATION

Remove all damaged metal with **ELECTRA** or by grinding. Preheat may be required for high alloy steels or cast iron. Total thickness of deposit should not exceed 1/4 inch with **OLYMPIA-A** and two passes for **OLYMPIA-B**. Build up to size with **APOLLO-A** or **POLARIS-A**

TECHNICAL

Size and Amps AC/DC ± 20%

Inches:	1/8	5/32	3/16*
(mm):	{3.2}	{4.0}	{4.8}
Amps:	110	140	170

With DC use reverse polarity. (DCEP)

*only Olympia A