

# OLYMPIA® - A FLUX CORE

Flux Core Arc Welding  
(FCAW - Gas Required)

For hardfacing low, medium, and high alloy steels.  
Resists abrasion and moderate impact.

## FEATURES

- Hardness 55-60 RC
- Forms chrome carbides
- Excellent abrasion and wear resistance
- Crack resistant
- Very low slag
- Good out-of-position resistance

## CHARACTERISTICS

**OLYMPIA-A FLUX CORE** is a small diameter, high efficiency, flux cored wire that may be applied with most wire feed equipment.

**OLYMPIA-A FLUX CORE** is suitable for high abrasion areas where the high deposition rate of wire welding is practical. A typical application would include dredge parts, extruder worms, bucket lips, dipper teeth, coal conveyers, miller tires, and drag line buckets.

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## APPLICATION

Use of 75-25 mix will decrease spatter. For vertical weave up and adjust voltage. Two passes will minimize base metal dilution.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045" (1.2mm)	20-28	130-210	1" - 1 1/2"

### SHIELDING GAS OPTIONS:

100% CO<sub>2</sub>

75% Argon- 25% CO<sub>2</sub>

