OLYMPIA® - B FLUX CORE

Flux Core Arc Welding
(FCAW)
For hardfacing, to resist abrasion on carbon steels, alloy steels, cast iron and manganese.

FEATURES

- Excellent severe abrasion resistance
- High hardness: 62-65 RC
- Supreme self-shielded running characteristics
- Mild impact resistance
- High heat hardness to 1200ºF (664ºC)
- Exceptionally high alloy content

CHARACTERISTICS

OLYMPIA-B FLUX CORE is a self-shielded hardface wire with an exceptionally high alloy content for resistance to extreme abrasion applications. The deposits also resist mild impact and high heat. Very suitable for vertical down-hand welding (.045 recommended).

OLYMPIA-B FLUX CORE has a special metal core composition which provides superior abrasion resistant alloying that includes chromium, molybdenum, boron and vanadium. A total alloy content that exceeds 15%, provides an excellent high hardness deposit. This is combined with excellent running characteristics and slag free deposits.

OLYMPIA-B FLUX CORE deposits will stress crack due to their high hardness. Deposits should be limited to 2 passes.

APPLICATION

Self-Shielded. An Argon/CO2 or 100% CO2 gas shield will enhance running characteristics. A 98/2 Argon/CO2 mix will allow spray arc transfers. Will run vertical down.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045"(1.2mm)	15-33	100-350	1/2 - 3/4"
1/16"(1.6mm)	20-33	160-400	3/4" - 1"

SHIELDING GAS OPTIONS:
Not required. Argon/CO_2 or 100% CO_2 will enhance running characteristics.