

## VENUS® - MIG

## Gas Metal Arc Welding (GMAW)

For welding bronze, brass, copper, cast-iron, steel and other dissimilar combinations. Excellent for welding galvanized steel.

### FEATURES

- High strength 60,000 psi
- Excellent wearing surface
- Color match on bronze
- Good corrosion resistance
- Low friction surface
- Hardness BHN 75

### CHARACTERISTICS

**VENUS-MIG** produces sound repairs and overlays on a wide variety of metals and dissimilar combinations. It also is recommended for use on cast-iron. Excellent results are obtained when joining steel to copper or brass.

Use **VENUS-MIG** on pumps, shafts or other bearing surfaces to produce a long-wearing, low friction surface. Deposits are smooth, dense and machinable.

### APPLICATION

Clean brass metal completely. Preheat 500°F (260°C) to 700°F (371°C) for sections over 1/4". Do not restrain joints while working.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft <sup>3</sup> /Hr)
.035"(0.9mm)	15-26	65-200	20-35
.045"(1.2mm)	22-28	150-250	35-40

### SHIELDING GAS OPTIONS:

100% Argon, 50% Argon-50% Helium, 75% Argon-25% Helium

## JUPITER® - MIG

## Gas Metal Arc Welding (GMAW)

For joining weldable types of cast iron such as grey, ductile, malleable and steel to cast iron.

### FEATURES

- 60,000 psi strength
- Machinable deposits
- Buildup or overlay
- Steel to cast iron joining

### CHARACTERISTICS

**JUPITER-MIG** is a special alloy which permits wire feed welding on cast iron for joining, build-up or overlays. It will also join carbon steel to cast iron. With proper procedures, deposits are machinable with no undercutting. This alloy allows high speed weld deposits on cast iron.

### APPLICATION

Appropriate cast iron preheat improves machinability and reduces stress in base metal. Use stringer beads with minimal weave. Peen to stress relieve. Pure Argon provides optimum running characteristics.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft <sup>3</sup> /Hr)
.045"(1.2mm)	19-22	150-170	25

**SHIELDING GAS OPTIONS:** 100% Argon, 75% Argon-25% CO<sub>2</sub>