

Shielded Metal Arc Welding (SMAW – Stick)

For joining, build-up and wear surfacing of all low alloy, manganese, medium and high carbon steels.

Features

- High Strength 135,000psi
- Shock and Abrasion Resistant
- Deposit 185 Brinell (11 RC)
- Work Hardens To 55 RC
- Cuts Easily With A Torch
- Excellent For Manganese Steels
- No Pre-Heat Or Peening
- Flux Coating Not Affected By Moisture
- Good Ductility
- Low Friction Surface

Characteristics

Apollo A has been developed to produce the most crack resistant welds for use on heavy equipment. Under impact, **Apollo A** work hardens considerably to resist wear. In addition, this alloy has extraordinary strength combined with excellent ductility (30% elongation). It is superior for metal-to-metal wear applications.

When equipment is exposed to stress, shock, impact or abrasion, **Apollo A** is an ideal welding material. Outstanding results are found on all critical joints and when impact is present as in rails, frogs and cross overs. Use for manganese wear plates, buckets, crushers, hammers, dragline chains and pins.

When even more wear resistance is required, final passes should be made with our **Olympia, Omega** or **Zeta** hard face alloys.

Technical

Size and Amps AC/DC $\pm 20\%$

Inches	1/8	5/32	3/16
(mm)	(3.2)	(4.0)	(4.8)
Amps	120	160	200

With DC use reverse polarity. (DCEP)

Application

- Remove all cracks or work hardened areas with **Electra**, or grind.
- Skip weld to avoid localized heat buildup.
- Weave no more than 2 to 3 times rod diameter.