

# APOLLO® - B

Shielded Metal Arc Welding  
(SMAW-Stick)

**ARC AC/DC**

All Positions

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For joining dissimilar steels. Also for build-up or hard surfacing.

## FEATURES

- High strength 105,000 psi
- Resistant to severe impact
- Superior ductility 37% elongation
- All purpose - joining and build-up
- Fast, easy deposition
- Tough, yet machinable
- Deposit hardness 20 RC
- Work hardens to 40-45 RC
- Good corrosion resistance and hot hardness to 1000°F (538°C)
- Alloy content 34%

## CHARACTERISTICS

**APOLLO-B** produces sound welds that combine excellent strength, impact resistance, abrasion resistance and joining properties. It can join stainless to carbon steel, and other combinations of dissimilar and hard-to-weld steels. The special low-hydrogen coating gives spatter-free welds and ease of operation in all positions. Ideal for build-up situations requiring tough but machinable deposits.

Applications include joining wedge bars to dipper teeth, repairing cracked crusher rolls, surfacing valve seats, and welding alloy steel lips to manganese buckets. **APOLLO-B** is also effective for building up manganese and carbon steels before overlaying with a very high abrasion resistant material, such as our Olympia, Omega or Zeta products.

## APPLICATION

Clean work surface and remove cracks. If welding over work hardened areas, use higher current on first pass. No preheat needed on most steels. Use stringer beads rather than weave. In joining, use heavy root pass.

## TECHNICAL

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

Inches:	3/32	1/8	5/32	3/16
(mm):	(2.4)	(3.2)	(4.0)	(4.8)

Amps:	85	130	175	245
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With DC use reverse polarity. (DCEP)