

JUPITER® - B

Shielded Metal Arc Welding
(SMAW-Stick)

For all meehanite, ductile, malleable, gray cast irons and steel to cast iron with superior machinability.

ARC AC/DC

All Positions

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FEATURES

- Strength 64,000 psi
- Maximum machinability
- Welds over dirt and oil
- No hard spots
- Crack free deposits
- No undercutting
- Low temperature deposits
- Welds over slag
- Excellent on weldable cast irons

CHARACTERISTICS

JUPITER-B has been developed to produce fully machinable welds on all grades of cast iron and cast iron to steel. These machinable deposits are often possible even without the benefit of preheat. This characteristic of **JUPITER-B** is made possible by avoiding the hard fusion zone encountered with conventional cast-iron welding electrodes.

In maintenance repair welding, it is often impossible to determine the grade of cast iron being repaired and dismantling equipment to prepare for welding will often cost more than actual repair. **JUPITER-B** provides significant savings through the repair of castings of unknown composition in place.

APPLICATION

Remove cracks and stop drill. Use medium arc and stringer beads. Skip weld and prevent overheating. Light peening recommended. For critical or heavy parts preheat to 500°F (260°C), cool slowly after welding.

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:	60	100	125	150
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With DC use reverse polarity. (DCEP)