

JUPITER® - BBB

Shielded Metal Arc Welding
(SMAW-Stick)

ARC AC/DC

All Positions

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

2

- Non-conductive coating eliminates side arcing
- Use in tight spots
- Good arc visibility
- Best weld appearance
- Soft stable arc
- Strength 65,000 psi
- Welds through dirt and oil
- Porosity free
- Easiest cast iron rod to use
- Excellent machinability
- Coating will not overheat even on AC

FEATURES CHARACTERISTICS

JUPITER-BBB has a special non-conductive coating, which permits welding in tight spaces without side arcing. It produces fully-machinable deposits and allows simple repair of defective, broken or worn castings, even in deep holes or out-of-position.

JUPITER-BBB has a soft stable arc and low-fuming characteristics that let the welder see and control the arc puddle.

Since **JUPITER-BBB** can generally be used without preheat, cast parts can often be repaired in place without disassembly.

APPLICATION

Use medium arc and stringer beads. Skip weld to prevent overheating. Light peening recommended. Preheat heavy or critical parts to 500°F (260°C). Cool slowly.

TECHNICAL

Size and Amps AC/DC ± 20%

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

Amps:	60	100	125
-------	----	-----	-----

With DC use reverse polarity. (DCEP)