

# VENUS® - A

# VENUS® - B

Shielded Metal Arc Welding  
(SMAW-Stick)

Bronze, brass & steel. For overlays,  
joining and dissimilar metals

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## FEATURES V/A

- High strength 50,000 psi
- Excellent wear surface
- Color match on bronze
- Low surface friction
- Hardness (BHN 75)
- High corrosion strength

## FEATURES V/B

- Strength 63,000 psi
- Excellent wear resistance
- Good salt water & chemical corrosion resistance
- Ductile deposit

## CHARACTERISTICS

**VENUS-A** has been designed for difficult to accomplish repair procedures. Excellent results are obtained when joining steel to copper or brass. When a long wearing overlay is called for, **VENUS-A** is an ideal electrode, producing low friction easily machined deposits.

**VENUS-B** is a very ductile (35% elongation) bronze electrode specially developed for joining and overlaying a wide variety of metals such as bronze, brass, steel & dissimilar combinations. Unlike other bronze electrodes, **VENUS-B** may be used on AC or DC equipment with low spatter and easy to remove slag. It is ideal for installing bronze wear pads on forklifts, etc. Use **VENUS-A** or **VENUS-B** on marine parts, gears, bearings, impellers, valve bodies, turbines, pumps and to repair flaws in new castings. Deposits are long wearing with low friction and resistant to attack by chemicals or salt water.

## APPLICATION

Bevel edges to a 45° vee. Use medium arc length. Preheat if necessary only on very heavy parts. Allow to cool partially before slag removal.

## TECHNICAL

Size and Amps AC/DC ± 20%

Inches:	*3/32	1/8	5/32	<b>*VENUS-B</b> only
(mm):	*(2.4)	(3.2)	(4.0)	
Amps:	65	100	150	

**VENUS-A** use DC reverse polarity. (DCEP)