

Apollo® B

Shielded Metal Arc Welding (SMAW – Stick)

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

Features

- High Strength 105,000psi
- Resistant To Severe Impact
- Superior Ductility (37% Elongation)
- For 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.

Technical

Size and Amps AC/DC ±20%

Inches	3/32	1/8	5/32	3/16
(mm)	(2.4)	(3.2)	(4.0)	(4.8)
Amps	85	130	175	245

With DC use reverse polarity (DCEP)

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.