

Olympia® B

Shielded Metal Arc Welding (SMAW – Stick)

For build up and hard facing carbon, low alloy high manganese steels and cast iron.

Features

- Deposited Hardness To 66 RC
- **Excellent Abrasion Resistance**
- Mild Impact Resistance
- Forms Ultra Hard Silicon Carbide
- Good Corrosion Resistance
- Deposits Contain Chrome Carbides

Characteristics

Olympia B has been developed to prolong the service life of equipment exposed to severe abrasion, even when combined with mild impact. The ease of use, long wear and high deposition rate make **Olympia B** a most economical hard facing metal.

Typical uses for **Olympia B** include bucket and loader lips, dredge pump impellers and housings, crusher jaws, screw conveyers, plow shoes, mixer chutes, and blades, etc.

Technical

Size and Amps AC/DC ±20%

Inches	3/32	1/8
(mm)	(2.4)	(3.2)
Amps	70	95

With DC use reverse polarity. (DCEP)

Application

- Remove all damaged metal with **Electra AAA** or by grinding.
- Preheat may be required for high alloy steels or cast iron.
- Total thickness of deposit should not exceed two passes for **Olympia B**.
- Build up to size with **Apollo A** or **Polaris A**.