

Jupiter[®] AAA

Shielded Metal Arc Welding (SMAW – Stick)

For all Meehanite, ductile, malleable, gray cast irons and steel to cast iron.

Features

- High Strength Up To 70,000psi
- No Electrode Overheating
- Smooth Ductile Deposits
- Steel To Cast Iron
- More Efficient Deposits
- All Weldable Grades Of Cast Iron
- Machinable Deposit
- Eliminates Porosity

Characteristics

Jupiter AAA is engineered to give the user a high strength ductile weld without electrode overheating, thus producing a much more efficient deposit that is machinable. Welds are typically smooth, porosity free and flat. Excellent tie in between passes.

Jupiter AAA makes it easier and more cost effective to do large cast iron repairs. It can be used on dirty and oil impregnated pieces without the problem of electrode overheating. Superior choice for joining cast iron to steel.

Technical

Size and Amps AC/DC $\pm 20\%$

Inches	3/32	1/8
(mm)	(2.4)	(3.2)
Amps	80	100

With DC use reverse polarity. (DCEP)

Application

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

Jupiter® A

Shielded Metal Arc Welding (SMAW – Stick)

For all Meehanite, ductile, malleable, gray cast irons and steel to cast iron.

Features

- High Strength 79,000psi
- Use On All Weldable Grades Of Cast Iron
- Welds Over Dirt and Oil
- Eliminates Porosity
- Ideal For Cast Iron To Steel Joining
- Prevents Hard Spots
- Easy To Use
- Welds Over Slag
- Ductile Deposits

Characteristics

Jupiter A has been engineered for the maintenance welder who must weld dirty, oil-soaked castings of unknown compositions. Sound, nonporous welds are produced without special preparation. Successful results are possible even when the joint is restrained.

Jupiter A makes it possible to repair machines and equipment in place without expensive tear down, thereby avoiding costly down time.

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)

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.

Jupiter® BBB

Shielded Metal Arc Welding (SMAW – Stick)

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

Features

- Non-Conductive Coating Eliminates Side Arcing
- Use In Tight Spots
- Good Arc Visibility
- Great Weld Appearance
- Soft Stable Arc
- Strength 65,000 psi
- Welds Through Dirt and Oil
- Porosity Free
- Excellent Machinability
- Coating Will Not Overheat Even On AC

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.

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)

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.