

Olympia® A

Shielded Metal Arc Welding (SMAW – Stick)

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

Features

- Deposited Hardness 52–54 RC
- Resists Abrasion
- **Good Impact Resistance**
- Work Hardens To 60 RC
- Build Up To 1/4"
- Excellent Out Of Position
- Deposits May Be Hot Forged

Characteristics

Olympia A is a universal hard surfacing alloy which produces a self-hardening deposit that resists both severe abrasion and impact. In addition, the high deposition rate significantly lowers application cost.

In maintenance welding, **Olympia A** is outstanding for extending the service life of parts such as crusher rolls, hammers, cutter heads, shovel buckets and teeth, pump housings and impellers, tractor rails, pins, hooks, conveyors and screws, tampers and augers, etc.

Technical

Size and Amps AC/DC ±20%

Inches	1/8	5/32	3/16
(mm)	(3.2)	(4.0)	(4.8)
Amps	110	140	170

With DC use reverse polarity. (DCEP)

Application

- Remove all damaged metal with **Electra AAA gouging rod** or by grinding.
- Preheat may be required for high alloy steels or cast iron.
- Total thickness of deposit should not exceed 1/4 inch with **Olympia A**.
- Build up to size with **Apollo A** or **Polaris A**.

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**.