

Olympia® B Flux Core

Flux Core Arc Welding (FCAW -Wire)

For hardfacing, to resist abrasion on carbon steels, alloy steels, cast iron and manganese.

Features

- Excellent Severe Abrasion Resistance
- High Hardness: 62 – 65 RC
- Unsurpassed Self-Shielded Running Characteristics
- Mild Impact Resistance
- Exceptionally High Alloy Content
- High Heat Hardness To 1200°F (664°C)

Characteristics

Olympia B Flux Core is a self-shielded hardface wire with an exceptionally high alloy content for resistance to extreme abrasion applications. The deposits also resist mild impact and high heat. Very suitable for vertical down-hand welding (.045 recommended). **Olympia B Flux Core** has a special metal core composition which provides superior abrasion resistant alloying that includes chromium, molybdenum, boron and vanadium. A total alloy content that exceeds 15%, provides an excellent high hardness deposit. This is combined with excellent running characteristics and slag free deposits. **Olympia B Flux Core** deposits will stress crack due to their high hardness. Deposits should be limited to two passes.

Technical

Inches	.045	1/16
(mm)	(1.2)	(1.6)
Volts	15-33	20-33
Amps	100-350	160-400
Stick Out	1/2" – 3/4"	3/4" – 1"

Use Reverse Polarity (DCEP)

Shielding Gas Options

- Not required.
- Argon/CO₂ or 100% CO₂ will enhance running characteristics.

Application

- Self-Shielded.
- An Argon/CO₂ or 100% CO₂ gas shield will enhance running characteristics.
- A 98/2 Argon/CO₂ mix will allow spray arc transfers.
- Will run vertical down.
- We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metal Working products section).

Spool Size

- 10# Available in .045
- 25# Available in .045 and 1/16"