

Omega[®] N

Shielded Metal Arc Welding (SMAW – Stick)

For hard facing all ferrous metals with excellent abrasion resistance under impact.

Features

- Hardness 60–62 RC
- Excellent Abrasion Resistance and Tough Deposits.
- Outstanding Weldability
- Low Friction, Smooth Deposit
- Holds Hardness At High Temperature
- Good Impact Resistance
- Fast Deposit
- Easy Slag Removable

Characteristics

Omega N prolongs service life of all types of equipment exposed to heavy abrasion even when combined with impact and elevated temperatures. These electrode deposits are ultra smooth and provide a low friction surface. Extra high deposition rates and easy slag removal make **Omega N** a favorite for a wide variety of surfacing jobs on manganese, carbon and alloy steels, as well as cast iron.

Omega N is ideal for wear surfacing the following components: Augers, conveyors, paddles, wear pads, screws, scrapers, shovel lips, bucket teeth, crusher jaws, drilling tools, and mixers.

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	80	110	150	180

With DC use reverse polarity. (DCEP)

Application

- Clean surface and remove all damaged metal.
- Use a medium arc with electrode at 45° to work.
- Weave as required.
- Preheat recommended for alloy steels or cast iron 200°F (149°C).
- Stress relieving cracks may appear.
- This does not reduce the integrity or wear resistance.