

Apollo® Flux Core

Flux Core Arc Welding (FCAW -Wire)

For welding low alloy and manganese steels, buildup, wear surfacing and joining.

Features

- 120,000psi Strength
- 40% Elongation
- Non-Magnetic Deposit
- Minimum Spatter Loss
- Deposits Can Be Flame Cut
- Deposit Thickness As Required
- Crack Resistant
- Austenite Micro-Structure
- Self Shielded

Characteristics

Apollo Flux Core is a self shielded high manganese alloy wire. It is the welder's choice for the tough buildup jobs, and for joining manganese to manganese or manganese to low alloy steels. **Apollo Flux Core** has an extra high chrome, nickel and manganese content which produces a weld that combines strength, ductility and crack resistance while work hardening under impact. **Apollo Flux Core** runs with a minimum of spatter and has a uniform slag coverage. The deposit can be flame cut, but it is difficult to machine. As deposited **Apollo Flux Core** is 200 Brinell (15RC) and will work harden to 550 Brinell (55RC). This provides outstanding metal-to-metal wear resistance in many applications. **Apollo Flux Core** also produces an extremely sound base build-up for a hard overlay of **Omega Flux Core**. If gas shielding is available, **Olympia Flux Core** or **Zeta Flux Core** would also be very suitable.

Technical

Inches	.045	1/16
(mm)	(1.2)	(1.6)
Volts	19-27	23-29
Amps	120-130	225-400
Stick Out	1/2" - 1"	1" - 1-1/2"

Use Reverse Polarity (DCEP)

Shielding Gas Options

- Self-Shielded
- 100% CO₂ will enhance weld bead, lessen spatter.

Applications

Proven applications are railroad frogs and crossings, hammer mill hammers, impact bars, shovel pads, tooth buildup, crusher rolls, dredge pump parts, drag line chains and pins.

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