

Orion B

Shielded Metal Arc Welding (SMAW – Stick)

Chromium-free alloy for hardfacing in extreme abrasion applications with light to moderate impact.

Features

- Chromium-Free Boron Carbide alloy
- Deposited Hardness of 65–69 RC in a single pass.
- Resists Extreme Abrasion
- 90% efficiency and very smooth running
- Can be easily cut with a torch
- Excellent for both industrial and agricultural wear applications

Characteristics

Orion B is the ultimate Chromium-free solution for extreme abrasion resistance with light to moderate impact. The rod is composed of **Boron Carbide** particles in a martensitic matrix. It produces incredibly hard and wear resistant deposits of 65–69 RC in a single smooth-running pass. This is both a highly efficient and effective product.

In maintenance welding, **Orion B** is outstanding for extending the service life of parts such as crusher rolls, cutter heads, shovel buckets and teeth, pump housings and impellers, hooks, conveyors and screws, augers, etc.

Technical

Size and Amps AC/DC ±20%

Inches	1/8	5/32	3/16
(mm)	(3.2)	(4.0)	(4.8)
Amps	115	140	190

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.
- **Orion B** is recommended for single pass usage.
- Build up to size with **Apollo A** or **Polaris A**.