

BRUTUS® - A

Shielded Metal Arc Welding
(SMAW-Stick)

For dissimilar and all categories of steel-tool, high alloy, nickel alloy, stainless, manganese and cast steels.

ARC AC/DC

All Positions

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FEATURES

- Superior strength 125,000 psi
- Easy to use in all positions
- Wear and shock resistant
- Prevents undercutting
- 35% elongation (ductile)
- Low heat requirements
- Excellent corrosion resistance
- No spatter
- Ideal for dissimilar steels
- Use for broken stud extraction
(See broken stud extraction page 95)

CHARACTERISTICS

BRUTUS-A is for the maintenance welder who often does not know the type of steel he is welding or must weld dissimilar steels. **BRUTUS-A** is easy to weld in all positions and produces sound super-strength yet ductile welds. These fully machinable deposits have no hard spots.

In many cases the maintenance welder is unable to weld on both sides of the joint. In these circumstances the use of **BRUTUS-A** with its superior strength and ductility is essential.

Excellent for use on tools, dies, pressure vessels, springs, stainless steels and dissimilar combinations. Ideal to build up shafting, agitator blades and for use on construction and mining equipment.

APPLICATION

Bevel heavy sections. Hold a short arc or drag. Use stringer beads. For high alloys and heavy sections preheat to 400°F (240°C), skip weld, and peen to avoid internal stress.

TECHNICAL

Size and Amps AC/DC $\pm 30\%$

Inches:	1/16	3/32	1/8	5/32
(mm):	(1.6)	(2.4)	(3.2)	(4.0)

Amps:	35	70	100	120
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With DC use reverse polarity. (DCEP)