

POLARIS® - AAA

Shielded Metal Arc Welding
(SMAW-Stick)

For high strength alloy and problem steels such as cast steel, Cor-Ten, nickel bearing and high grade structural steels.

ARC AC/DC

All Positions

FEATURES

- Excellent strength 98,000 psi
- Excellent AC stability
- Welds cast steel
- Moisture proof, low hydrogen
- Can be torch cut
- All positions
- Outstanding ductility 34% elongation
- Free machining
- Excellent sub-zero properties
- X-ray quality welds
- No undercutting
- Stable arc

CHARACTERISTICS

POLARIS-AAA produces sound, heat-treatable welds, even on contaminated metals. Welds have unusual strength and ductility, even at sub-zero temperatures. Welding is easy in all positions and deposits are free machining.

Applications include all construction equipment, boilers, tanks, piping, vehicle frames, and all crack sensitive steels. Its extraordinary ductility makes

POLARIS-AAA a good hard-surfacing pad.

APPLICATION

Use close arc length. For vertical welds, lower amperage, weld from bottom up and weave. Do not whip. Overhead and horizontal, use stringer beads. Down hand, weave a maximum of 2 1/2 times rod diameter. Always preheat heavy sections.

TECHNICAL

Size and Amps AC/DC $\pm 20\%$

Inches:	3/32	1/8	5/32	3/16
(mm):	(2.4)	(3.2)	(4.0)	(4.8)

Amps:	85	120	160	220
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With DC use reverse polarity. (DCEP)