

# 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.

### 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.

### 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	85	120	160	220

With DC use reverse polarity. (DCEP)

### 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.