

Felix 113 DC

Premium All Position Electrode For Welding 400 , 404 And K-500 Monel Alloys .



Special Features

- * Excellent Resistance To Corrosion By Sea Water , Alkalis , Acids Like Hydrofluoric And Sulfuric .
- * Porosity Free Joints With High Ductility And Crack Resistance .
- * Unique Chemistry With Good Strength And Thermal Conductivity .

Typical Properties

Tensile Strength	75000 PSI
Yield Strength	54000 PSI
Elongation	36 %

International Specifications

AWS/ASME A 5.11 E NiCu-7
DIN 1736 : EL NiCu30Mn

Applications

- * Ideal For Welding Pumps , Heat Exchangers , Evaporators , Valves . Propeller Shafts In Chemical , Marine , Petrochemical Fertilizer Industries Etc .
- * Ideal For Welding Monel Alloys To Themselves To Copper To Carbon Steels To Stainless Steels . Used Also For Cladding Of Steels .

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	40	70	90
Maximum Amperage	70	100	130

Welding Techniques

Clean Weld Area . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 250 °C For 2 Hour . Stringer Beads Or Weaving Technique Can Be Used . Maintain Short Arc For Best Mechanical Properties . Use DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite