

Felix 122 AC-DC

Premium All Position Electrode For Joining 600 And 601 Inconel Alloys .



Special Features

- * Excellent Resistance To Oxidation And Corrosion Coupled With High Temperature Strength .
- * High Strength Electrode Meeting Stringent Radiographic Requirements .
- * All Position Electrode With Easy Slag Removal And High Operator Appeal .
- * Unmatched Elongation And Unique Chemistry Helps Dissolve Hydrogen Hence Preventing Cold Cracking .

Typical Properties

| | |
|------------------|-----------|
| Tensile Strength | 98000 PSI |
| Yield Strength | 60000 PSI |
| Elongation | 43 % |

Applications

- * Ideal For Joining Nickel Based Alloys To Themselves To Alloyed Steels To Dissimilar Steels To Stainless Steels . Typical Applications Are Furnace Components , Cement Kiln Support Rollers , Repair Of High Strength Steels , Oven Parts , Burners , Heat Treatment Equipment Etc .

International Specifications

AWS/ASME IIC A 5.11 : ENiCrFe-3
DIN 1736 : EL-NiCr15FeMn

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 . The Area In Which Weld Is To Be Made Should Be Free Of Rust , Grease , Paint And Other Material . Adjust Amperage Within Recommended Range And Deposit Electrode , Maintaining A Short To Medium Arc Length. Back-Whip Craters And Remove Slag Between Passes Where Ever Possible . Peening To Release Stresses In Beneficial . DC Reverse Polarity (Electrode +) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite