

Felix 131 AC-DC

Premium Rutile Based Electrode For Applications Involving Thermal Shock With High Resistance To Corrosion .



Special Features

- * Cr - Ni - Mo Alloyed Deposits For Unmatched Resistance To Corrosion , Impact And Abrasion At Elevated Temperatures .
- * Deposits Work Harden Without Deformation When Subjected To Impact And Pressure .
- * High Resistance To Corrosion In All Types Of Alkalies , Oxidizing And Reducing Acids .
- * Good Welder Appeal With Low Spatters And Easy Slag Removal .

Typical Properties

Tensile Strength	98000 PSI
Yield Strength	60000 PSI
Elongation	43 %
Hardness	18 - 20 HRC
As Work Hardened	43 - 45 HRC

Applications

- * Ideal For Repair Welding And Build Up Of Hot Forging Dies , Forge Saddles , Hot Trimming Dies , Shear Tools , Pump Gears And Valves , Moulds Etc And Joining Of Nickel Alloys To Themselves To Stainless Steels To Low And Medium Alloyed Steels .

International Specifications

AWS/ASME A 5.11E NiCrMo - 5

Recommended Amperage Settings

Diameter(mm)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	80	120
Maximum Amperage	120	150

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 . Peening To Release Stresses In Beneficial . DC Reverse Polarity (Electrode +) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite