Felix 231 AC-DC

Highest Crack Resistant High Tensile Electrode For Joining All And Any Steels Including Dissimilar Steels .

Special Features

* Special Flux Formulation Produces A Homogeneous , Porosity Free Machinable Weld Deposit .
* Tensile Strength Increases In Use Due To Its Work Hardening Qualities Giving The Most Reliable Welds .
* Excellent Spray Arc Transfer And Easy Slag Removal .
* High Corrosion And Heat Resistance .
* Shock And Impact Resistance Equivalent To Manganese Alloy Steels And Other Steels Designed For Impact Applications .

Typical Properties

Tensile Strength	122000 PSI
Tensile Strength As Work Hardened	186000 PSI
Yield Strength	90000 PSI
Elongation	30%
Hardness	245 Brinell

International Specifications

AWS/ASME A 5.4 E 312-17
DIN 8556 : E 29.9 R 23
ISO 3581: E 29.9 R 32

Applications

* Weld All Tool Steels , Manganese Steels And Speciality Steels In Thick To Thin Designs . Ideal For Joining Tool Steels , Spring Steels , Manganese Alloyed Steels , Rail Steels And Cast Steels .

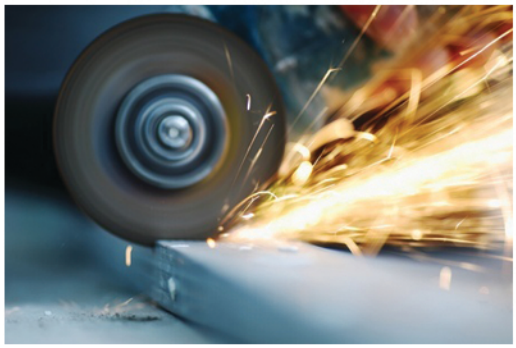
* Weld All Carbon And Alloy Steels - Low-Medium-High In All Positions , Under All Conditions , Including Dissimilar Combinations .

Recommended Amperage Settings

Diameter(mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	35	60	80
Maximum Amperage	55	75	100	120

Welding Techniques

Clean Surface . Bevel Heavy Sections To Be Joined . Adjust Amperage Within Recommended Range And Deposit Electrode , Maintaining A Short To Medium Arc Length . Tilt The Electrode 15° In The Direction Of Travel . Back - Whip Craters And Remove Slag Between Passes Whereever Possible . On High Tool Steels It Is Advisable To Preheat According To Base Metal To Obtain Best Results . DC Reverse Polarity (Electrode +Ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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