

# Felix 311 AC-DC

Premium Multipurpose Electrode For Gauging , Chamferring ,  
Cutting & Piercing .



## Special Features

- \* Blasting Arc Yielding High Speed And Clean Cutting And Gauging .
- \* No Compressed Air Or Oxygen Required .
- \* Excellent All Position Welding And Restrike Capability .
- \* Designed To Operate On All Types Of Welding Machines With Limited Capacity .

## Applications

- \* Ideal For Gouging , Cutting And Chamfering Of Unalloyed And Low Alloyed Steels , Cr-Ni , Cr-Ni-Mo And Other Alloyed Stainless Steels , Different Grades Of Cast Irons , Cast Steels , Aluminums And Copper For Which The Oxy-Fuel Cutting Methods Are Not Applicable .

## International Specifications

Proprietary Product

## Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	140	200	280
Maximum Amperage	230	310	430

## Welding Techniques

Initiate Arc By Holding Electrode At A Low Angle To The Workpiece (10° To 15°) . Push The Electrode As Fast As The Metal Is Removed . Maintain Shorter Arc For Faster And Cleaner Cut . For Piercing Hold Electrode Vertically And Push In And Out . For Cutting Action Use Sawing Action Technique .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite