

Felix 419 DC

Premium Aluminium Bronze Electrode For Joining And Surfacing Copper Alloys .



Special Features

- * High Resistance To Wear , Cavitation And Corrosion In Mediums Like Sulfuric Acid , Sea Water Etc .
- * Can Be Used For Welding Copper Alloys To Various Grades Of Weldable Cast Irons To High And Low Carbon Steels .
- * Stable Arc With Easy Slag Removal .
- * Excellent Mechanical Properties With Adequate Electrical Conductivity .

Typical Properties

Tensile Strength	65000 PSI
Hardness	Brinell 145
Elongation	22 %

Applications

- * For Welding Of Ship Propellers , Pump Housings , Piston Heads , Bearings , Copper-Zinc Alloys , Copper-Nickel Alloys , Silicon And Manganese Bronze And Bronze Of Similar Composition . Can Be Used For Surfacing On Cast Irons , Steels And Copper Alloys .

International Specifications

AWS/ASME A 5.6 E CuAl - A2
DIN 1733: EL-CuAl9

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	80	100
Maximum Amperage	110	140

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . Preheating At 450-650° C Is Required For Heavier Sections . DC Reverse Polarity (Electrode +Ve) .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite