

Felix 509 AC-DC

Premium Basic Coated Low Heat Input Electrode For Welding Of Low Alloy High Strength Steels .



Special Features

- * Excellent Resistance To Cracking On Low Alloy Steels Subjected To High Static And Dynamic Stresses .
- * Balanced Alloying Elements Provide High Tensile Strength With Excellent Toughness .
- * Low Hydrogen X - Ray Quality Weld Deposits With High Metallurgical Purity .
- * Good Operator Appeal With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

Typical Properties

Tensile Strength	94000 PSI
Yield Strength	83000 PSI
Elongation	26%

Applications

- * Ideal For Welding Pressure Vessels , Vehicle Chasis , Heavy Machinery , Penstocks , Cushion Layer Prior To Hard Facing , Cranes , Trailer Frames , Steel Castings Etc .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Length	350	350	350
Minimum Amperage	60	90	130
Maximum Amperage	85	130	180

Welding Techniques

Clean Weld Area . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 300° C For 2 Hour . Stringer Beads Or Weaving Technique Can Be Used . Maintain Short Arc For Best Mechanical Properties . Use DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite