

# Felix 518 AC-DC

Premium Basic Coated High Strength Austenitic Electrode For Joining Dissimilar Steels Combinations .



## Special Features

- \* Highly Ductile Weld Deposits With Excellent Resistance To Cracking .
- \* Weld Deposits Work Harden When Subjected To Impact And Preassure .
- \* Weld Deposits Are Non Scaling Upto 850 ° C And Can Withstand Temperature Upto 300 ° C .
- \* Good Operator Appeal With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

## Typical Properties

Tensile Strength	102000 PSI
Yield Strength	71000 PSI
Elongation	40%

## Applications

- \* Ideal For Welding High Manganese Steels , Crane Wheels , Cast Steel Parts , Austenitic Manganese Steel Components Subjected To Static And Dynamic Loads , Preassure , Impact And Abrasion .
- \* Ideal For Joining Difficult To Weld Dissimilar Steels And For Stress Free Deposits Before Hardfacing .

## International Specifications

Propreitory 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	75	100
Maximum Amperage	80	100	130

## 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