

Felix 527 AC-DC

Premium Low Heat Input Electrode For Joining Heavy Sections Of Austenitic Manganese Steels To Itself And With Dissimilar Steel Compositions.



Special Features

- * Highly Ductile Weld Deposits With Excellent Resistance To Cracking .
- * Specially Formulated Weld Deposits For High Resistance To Abrasion And Impact .
- * Good Results When Used As Buffer Layer Prior To Hardfacing . Also Used For Joining Dissimilar Steels .
- * Good Operator Appeal With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

Typical Properties

Tensile Strength	97000 PSI
Yield Strength	72000 PSI
Elongation	35 %

Applications

- * Typical Application Include Joining And Crack Repairing Heavy Sections And Castings Of Austenitic Manganese Steels And Steels Like Crusher Hammers , Dipper Teeth , Rebound Crushers , Excavators Parts , Conveyor Buckets , Grader Blades , Coal Crusher Segments .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	50	65	80	110
Maximum Amperage	70	90	120	140

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 AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite