

# Felix 610 AC-DC

Premium Deep - Penetrating , Cellulosic Mild Steel Electrode  
For All - Position Welding .



## Special Features

- \* Good Results On Rusted , Galvanised And Contaminated Mild Steels .
- \* Quiet Stable Arc With Easy Slag Removal And Minimal Slag Entrapment .
- \* All Welding Position Electrode With High Welder Appeal And Excellent Weld Appearance .
- \* High Penetration Electrode Specially Suitable For Root Pass And Fill Passes In Vertical Down Direction .

## Typical Properties

Tensile Strength	72000 PSI
Yield Strength	62000 PSI
Elongation	26 %

## Applications

- \* Typical Applications Include Root Passes On High Strength High Pressure Pipe Steels , Bridges , Industrial Fabrication , Ship Building , Automotive Chassis And Framework Etc .

## International Specifications

AWS/ASME A 5.1 E 6010  
ISO 2560A E 42 2 C 25

## Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Length	350	350	350	350
Minimum Amperage	30	45	75	120
Maximum Amperage	70	100	130	200

## Welding Techniques

Maintain A Short - Medium Arc Length At Low Amperage . Clean Weld Area . Use A Medium Long Arc With High Amperages On Contaminated Steels . Stringer Beads Or Weaving Technique Can Be Used . Multi Pass Welding Possible Without Slag Removal . Use AC Or DC Reverse Polarity .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite