

Felix 617 AC-DC

Premium All Position Electrode For Welding Of Fine Grained Unalloyed Structural Steels .



Special Features

- * High Speed Electrode With High Ductility And Good Mechanical Properties .
- * Quiet Stable Arc With Easy Slag Removal And Minimal Slag Entrapment .
- * High Welder Appeal With Excellent Weld Appearance .
- * Good Results On Both AC And DC Machines .

Typical Properties

Tensile Strength	82000 PSI
Yield Strength	70000 PSI
Elongation	30%

Applications

- * Typical Applications Include Bridges , Rolling Stocks , Heavy Machinery , High Sulfur Steels , Hardenable Steels , Free Cutting Steels , Unalloyed Structural Steels , Cold Rolled Steels And Medium Carbon Steels .

International Specifications

AWS/ASME A 5.1 E 7016
ISO 2560: E 515 B 26

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Length	350	350	450	450
Minimum Amperage	60	80	120	190
Maximum Amperage	90	110	160	230

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