

Felix-653 (AWS-7018-1)

Premium Thick Coated Basic Low Hydrogen Type Electrode With Exceptionally High Mechanical Properties .



Special Features

- * Weld Deposits Exhibit High Toughness Levels Even At -50° F .
- * Excellent Results On High Carbon Steels And Low Alloy Steels Subjected To High Static And Dynamic Stresses .
- * Low Hydrogen X - Ray Quality Weld Deposits With High Metallurgical Purity .
- * Quiet Stable Arc With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

Typical Properties

Tensile Strength	79000 PSI
Yield Strength	65000 PSI
Elongation	28%
Impact Energy ISO-V	110 J At -46° C

Applications

- * Typical Applications Include Unalloyed Construction Steels , Carbon Manganese And Low Alloy Steels , Mining Equipments , Locomotive Construction , Heavy Structures , Ship Building , Farm Machines , Boiler Plates , Pressure Vessels , Heavy Machinery Etc Where High Mechanical Properties Are Required .

International Specifications

AWS/ASME A5.5 : E7018-1

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	450
Minimum Amperage	60	90	130	180
Maximum Amperage	85	130	180	230

Welding Techniques

Clean Weld Area . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 350° C For 2 Hour .
Stringer Beads Or Weaving Technique Can Be Used . Maintain Short Arc For Best Mechanical Properties .
For Best Results DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite