

Felix 824 AC-DC

Premium High Strength Iron Based Non Machinable Electrode
For Contaminated Cast Irons .



Special Features

- * Good Results On Contaminated , Oil Soaked And Heat Oxidised Cast Irons .
- * High Resistance To Cracking .
- * Specially Formulated Flux Produces High Arc Force To Flush Away Impurities And Give Posrosity Free Welds .
- * Excellent Colour Match With The Base Metal .

Typical Properties

Tensile Strength	60000 PSI
Yield Strength	46000 PSI
Hardness	39 HRC

Applications

- * Ideal For Repair Of Cracked Machine Bases , Burned Furnace Grates , Pedestals , Oil Pans , Frames And Housings , Dies , Agricultural Equipment , Build - Up Of Abrasion Worn Areas , Pump Housings And Low Quality Cast Iron Etc .
- * Used Also For Joining Cast Iron To Steel .

International Specifications

AWS/ASME A 5.15 Est
DIN 8573 : E Fe-1
ISO 1071: E Fe

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	50	70	90
Maximum Amperage	80	120	130

Welding Techniques

Remove All Rust And Scale From The Surface To Be Welded . Adjust Amperage Within Recommended Range And Deposit Electrode Maintaining A Short To Medium Arc Length . Tilt The Electrode In The Direction Of Travel . Use Stringer Bead Or Moderate Weave Technique And Back-Whip All Craters. Use Reverse Polarity On DC / AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite