

Felix 842 AC-DC

55 % Nickel High Strength Electrode For Joining Cast Iron To Cast Iron To Steel .



Special Features

- * High Reliability On Contaminated Oil Soaked And Dirty Cast Irons .
- * Weld Deposits With Low Coefficient Of Thermal Expansion Resulting In Little Shrinkage And No Cracks .
- * Specially Formulated Flux For Deposits Free Of Porosity .
- * Perfect Colour Match With The Base Metal .
- * Good Resistance To Compression , Friction , Wear And Vibration .

Typical Properties

Tensile Strength	65000 PSI
Yield Strength	48000 PSI
Hardness	180 Brinell

Applications

- * Ideal For Repair Of Casting Defects , Machine Bases , Pump Casings , Gear Boxes , Piping systems (Tubing, Valves Etc.) , Transmission Mountings , Engine Blocks And Structures Such As Pedestal , Frames , Housings And Casting Shapes Of All Types .
- * Used Also For Joining Cast Iron To Steel .

International Specifications

AWS/ASME A 5.15 E NiFe-CI-A
DIN 8573: E NiFe BG13
ISO 1071: ENiFe

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	60	90	110
Maximum Amperage	90	120	140

Welding Techniques

Remove All Rust , Scale 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 . Good Results On Both AC And DC Machines .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite