Felix 845 AC-DC

Premium Graphite Type High Strength Electorde For Joining Cast Iron To Cast Iron To Steel .

Special Features

* Extra Strong Arc Drive For High Reliability On Contaminated , Oil Soaked And Dirty Cast Irons .
* Addition Of Extra Nickel In Flux For High Resistance To Cracking And Enhanced Machinability .
* Special Flux Formulation To Ensure High Efficiency Weld Metal Transfer Eliminating Overheating Of Electrode .
* Perfect Colour Match With The Base Metal .
* Smooth And Spatter Free Operation Providing High Quality Porosity Free Weld .

Typical Properties

Tensile Strength	70000 PSI
Yield Strength	48000 PSI
Hardness	180 Brinell

Applications

* Ideal For Repair Of Housings For Pumps , Valves , Casting Defects , Sprockets , Machine Bases , Gear Boxes , Transmission Mountings , Engine Blocks And Welding Nodular Cast Iron , White And Black Heart Malleable Cast Iron , Austenitic Nodular Cast Iron Etc .
* Ideal For Welding Cast Iron With Dissimilar Steels .

International Specifications

AWS/ASME A 5.15: ENiFe-CI
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

Email : sales@ferrsol.com | Web : www.ferrsol.com