Felix 869 AC-DC

Premium Low Hydrogen Low Hardness Electrode For Building Up Oil Soaked Cast Iron Draw Dies Without Porosity .

Special Features

* The Deposited Metal Shows Low Hardness But Becomes Moderately Hard .
* Versatile Cast Iron Electrode For Building Up Of Wearing Surfaces On All Types Of Iron Draw Dies Including Gray , Nodular , Ductile And Special Cast Alloys .
* Special Alloying Chemistry Of Felix 869 AC-DC Produces Homogeneous Porosity Free Weld Deposits On Contaminated Cast Irons .
* Smooth And Spatter Free Operation With High Resistance To Impact .

Typical Properties

Hardness	18-20 HRC
As Work Hardened	26-30 HRC

International Specifications

Propreitory Product

Applications

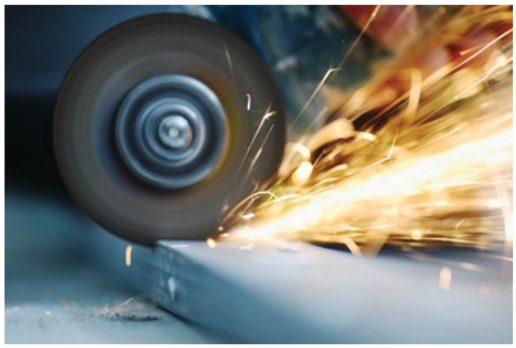
* Used On Cast Iron Draw Dies Including Gray , Nodular , Ductile And Special Cast Alloys Subjected To Metal To Metal Erosion . Excellent Results On Draw Surfaces Where Similar Hardness As of Base Material Is Required To Prevent Hard Spots .

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 , Drawing Compound And Oil From The Surface To Be Welded. Preheating To 150° C Is Effective Though In Many Cases Not Necessary . Recommended Use Of Felix 842 If No Of Layers Exceed More Than Three . Use As Low A Current As Possible . Peen Rapidly To Help Relieve Stresses . Clean Off Slag Between Passes . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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