

# Felix 878 AC-DC

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



## Special Features

- \* First Deposited Layer With Austenitic Structure And Second Layer And Onwards Having Martensitic Structures Gives Weld Deposits With High Abrasion Resistance .
- \* 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 878 AC-DC Produces Homogeneous Porosity Free Weld Deposits On Contaminated Cast Irons .
- \* Deposits Are Long Wearing And Develop A High Polish While In Service .
- \* Smooth And Spatter Free Operation With High Resistance To Impact .

## Typical Properties

Hardness	32-34 HRC
As Work Hardened	38-40 HRC

## International Specifications

Proprietary 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 Beads , Hold Down Beads , Draw Radii Areas On Female Dies Where High Hardness Is Required .
- \* Excellent Results On High Alloy Tool Steel Dies Made From D2 , D6 , D7 And Other High Carbon Alloy Steels .

## 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