Felix 905 AC-DC

Premium Cobalt Based Electrode With Extreme Resistance To Abrasion .

Special Features

* Higher Carbon And Tungsten For Extreme Resistance To Abrasion At Elevated Temperatures (900° C) .
* Cobalt Based Stellite Grade 1 Alloy For High Edge Retention At Elevated Tempratures .
* Welders Delight With Easy Restrike , Low Spatters And Easy Slag Removal .
* Excellent Results On Both AC And DC Machines .

Typical Properties

Hardness	52 - 56 HRC
As Work Hardened	58 - 60 HRC

Applications

* Typical Applications Include Mixer Blades , Wire Guides , Valve Seats , Saw Blades , Extrusion Dies And Screws , Carbon Scrapers , Steam Turbine Parts , Pump Sleeves Etc .

International Specifications

AWS/ASME A 5.13 E CoCr-C

Recommended Amperage Settings

Diameter(mm)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	80	100
Maximum Amperage	110	140

Welding Techniques

Clean Weld Area . Stringer Beads Or Minimal Weaves Can Be Used With Short Arc Lengths . Preheat The Job Wherever Possible Specially Complex Profiles . Slow Post Weld Cooling Is Advised . Recommended Use Of Felix 230 As Buffer Layer If No Of Layers Exceed More Than Three . Use AC Or DC Reverse Polarity .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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