

Felix 910 AC-DC

Premium Cobalt Based Electrode With High Resistance To Abrasion And Thermal Shocks .



Special Features

- * Addition Of Tungsten For Good Resistance To Hot And Cold Abrasion At Elevated Temperatures (900° C) .
- * Cobalt Based Stellite Grade 21 Alloy For High Resistance To Wear , Galling And Corrosion At Elevated Temperatures .
- * Welders Delight With Easy Restrike , Low Spatters And Easy Slag Removal .
- * Excellent Results On Both AC And DC Machines .

Typical Properties

Hardness 45 - 50 HRC
As Work Hardened 55 - 58 HRC

Applications

- * Typical Applications Include Valve Seats , Extrusion Screws , Forging Dies , Punches And Industrial Knives For Cutting Paper , Cardboard , Floor Coverings , Roofings Etc .

International Specifications

AWS/ASME A 5.13 ECoCr - E

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