Felix 914 AC-DC

Premium Cobalt Based Electrode With High Resistance To Impact And Cracking .

Special Features

* High Heat And Corrosion Resistant Weld Deposits At Operating Tempratures Upto 900° C .
* High Toughness Of Weld Metal Gives High ResistanceTo Mechanical And Thermal Shocks .
* Cobalt Based Stellite Grade 6 Alloy For High Temprature Hardness Retention .
* Welders Delight With Easy Restrike , Low Spatters And Easy Slag Removal .

Typical Properties

Hardness	38 - 42 HRC
As Work Hardened	44 - 48 HRC

Applications

* Typical Applications Include Valve Seats , Hot Shear Blades , Forging Dies , Gates , Pump Shafts , Bearings , Ingot Tong Ends , Glass Dies Etc Used In Chemical , Steel , Power , Sugar And Other Process Industries .

International Specifications

AWS/ASME A 5.13 ECoCr - A

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 266 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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