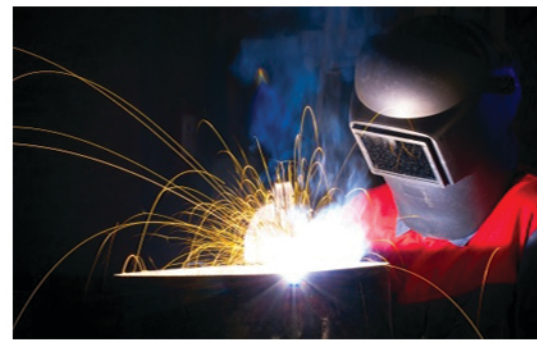


# Felix 923 AC-DC

Excellent Work Hardening Cobalt Based Electrode With High Resistance To Impact And Cracking .



## Special Features

- \* Addition Of Molybdenum For Excellent Work Hardening Properties And Good Corrosion Resistance .
- \* High Toughness Of Weld Metal Gives High Resistance To Thermal Cycles And Shocks .
- \* Cobalt Based Stellite Grade 21 Alloy For High Temperature Strength And Stability (1600° F) .
- \* Welders Delight With Easy Restrike , Low Spatters And Easy Slag Removal .

## Typical Properties

|                  |             |
|------------------|-------------|
| Hardness         | 28 - 32 HRC |
| As Work Hardened | 42 - 45 HRC |

## Applications

- \* Typical Applications Include Valve Bodies And Seats , Drop Forging Dies , Pump Shafts And Sleeves , Hot Shear Blades , Valve Mill Screws , Trimming Dies , Extrusion Dies , Gas Turbines 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