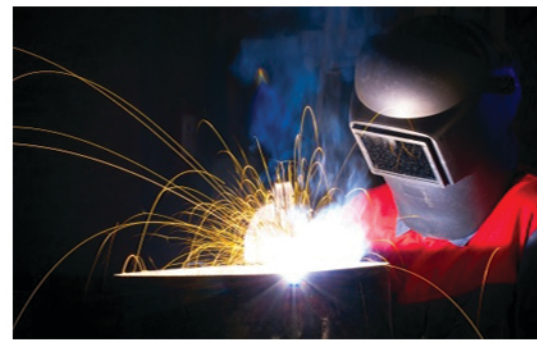


Felix 941 AC-DC

Premium Quality Medium Hardness Electrode For Most Tool Steels With High Toughness .



Special Features

- * Weld Deposits Have A Martensitic Structure With Some Dispersed Carbides To Give It High Hardness .
- * Special Alloying Chemistry Enables Multiple Layers With This Electrode For High Buildups .
- * Unmatched Toughness Enables This Product To Take On Sudden Shock .
- * Excellent Crack Resistance Even On Thorough Hardened Tool Steels .

Typical Properties

Hardness	42 - 45 HRC
As Work Hardened	52 - 55 HRC

International Specifications

Proprietary Modification

Applications

- * Used Specially On Tools And Dies Of The 5% Chromium Type And The High Carbon High Chromium Types . Typical Application Include Extrusion Dies , Blanking Dies , Coining Dies , Forming Dies , Cutting Dies , Shears And Other Cutting Edges .

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	60	80	100
Maximum Amperage	80	100	130

Welding Techniques

Clean Weld Area . It Is Not Required To Preheat But If Base Metal Is Highly Carbonized It Should Be Preheated To Appox 350° C . Build Part To Desired Shape By Using As Many Passes As Necessary . Heat To Bright Red Colour . Peen To Relive Stresses And Remove Slag Between Passes . Use DC Reverse Polarity 35 .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite