

Felix Durabond XS AC-DC

Premium Iron Powder - Low Hydrogen All Position Electrode
For Welding Low , Medium And High Carbon Steels .



Special Features

- * Superior Electrode With High Deposition Rate .
- * Exceptional Mechanical Properties And A Smooth Uniform Bead Appearance .
- * X - Ray Quality Welds With Easy Slag Removal .
- * Steady Arc With Low Spatter And High Operator Appeal .

Typical Properties

Tensile Strength	82000 PSI
Yield Strength	68000 PSI
Elongation	28%
Impact Energy	90J : -30° C

Applications

- * Cold Rolled Steels Such As Found In Heavy Machinery Fabrications , Boiler And Pressure Vessels , Bridges And Structural Steels , Cast Steels , Shipbuilding , Buffer Layer Prior To Hard Facing , General Maintenance Or Production Fabrication .
- * Low , Medium And High Carbon Steels Subjected To X - Ray Inspection .

International Specifications

AWS/ASME A 5.1 E 7018
DIN 1913 : E51 54B R 10
ISO 2560 : E51 5B120 26H

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	1/8 (3.15)	5/32 (4.0)	5/32 (4.0)	3/16 (5.0)
Length	350	350	450	350	450	450
Minimum Amperage	60	90	90	130	130	180
Maximum Amperage	90	130	130	180	180	230

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Re-Drying Is Not Required . If necessary Redry At 250° C for 1 Hour . Felix Durabond XS Electrodes May Be Used In Any Position With AC Or DC (Straight Or Reverse Polarity) .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite