

# Felix Hibond LR AC-DC

General Purpose High Strength Electrode For Welding of Complicated Structures Of Mild And Carbon Steels .



## Special Features

- \* Low Welding Fumes With Less Spatter .
- \* Good Electrode Restrike .
- \* Easily Removable Slag .
- \* Smooth Welding Beads Without Undercuts .

## Typical Properties

Tensile Strength	67000 PSI
Yield Strength	58000 PSI
Elongation	26%
Impact Energy (1SO-V/+20° C)	Min 47 J

## International Specifications

AWS/ASME A E 6013  
EN 499 : E 38 2 R 12  
EN ISO 2560-A : E 38 2 R 12

## Applications

- \* Used For The Welding Of Mild Steels , Galvanized And Some Low Alloy Steels , Automobile Bodies , Truck Frames And Bodies , Ship Building And Repair , Farm Machinery , Ornamental Iron , Metal Furniture , Equipment , Building Structures , Farm Implementations , Machinery Guards , Storage Tanks And General Light Fabrication .
- \* Industries - Refinery , Chemical , Petrochemicals , Textile Etc .

## 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	40	80	80	110	110	160
Maximum Amperage	80	120	120	150	150	240

## 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 : 100° C For 1 Hour . Felix Hibond LR Electrodes May Be Used In Any Position With AC Or DC ( Straight Or Reverse Polarity ) .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite