

Felix 203 DC (307-15)

Premium Basic Coated Crack Resistant Electrode For Joining Dissimilar Steels And Manganese Alloyed Steels .



Special Features

- * Deposits Consist Of Austenitic Cr - Ni - Mo Steel With Amounts Of Delta Ferrite .
- * Scaling Resistance Upto 850° C And Operating Temperatures For Dissimilar Joints Is 350° C .
- * Smooth Running Electrode For Easy Slag Removal With Excellent Weld Appearance .
- * Deposits Are Highly Crack Resistant .

Typical Properties

Tensile Strength	100000 PSI
Yield Strength	55000 PSI
Elongation	40%

Applications

- * Armour Plates , Rails , Crane Wheels , Steel Castings , Cross Over , Manganese Steel To Carbon Steel Forgings , Joining Work Hardenable Steel Etc . Ideal As A Buffer Layer On Difficult To Weld Steels Before Hardfacing .

International Specification

AWS/ASME A 5.4 E 307-15

DIN 8555 : E 18 8 Mn B 22

ISO 3581: E 18 8 Mn B 22

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	45	80	100	150
Maximum Amperage	80	110	140	180

Welding Techniques

Clean Weld Area . Stringer Beads Or Weaves Can Be Used With Short Arc Lengths . If Necessary Redry For 2 Hours At 300° C . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite