

Felix 731 AC-DC

Premium Basic Coated Medium Hardness Electrode For High Resistance To Compressive Loads .



Special Features

- * Air Hardening Chromium Alloyed Electrode For High Resistance To Compressive Loads .
- * High Resistance To Deformations Due To Rolling Forces .
- * Smooth Porosity Free Deposits With Easy Slag Removal And Excellent Weld Appearance .
- * Excellent Performance On Both AC And DC Machines .

Typical Properties

Hardness 27-30 HRC

Applications

- * Ideal For Hardfacing Of Gears , Rollers , Crane Wheels , Shafts , Valves , Rails , Caterpillar Track Rollers , Rail Crossing Sections , Traction Gears And Parts Subjected To Impact , Compression And Metal To Metal Friction .

International Specification

DIN 8555 : E1 UM-300

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	70	90	120	150
Maximum Amperage	90	120	140	180

Welding Techniques

Clean Weld Area . Stringer Beads Or Weaves Can Be Used With Short Arc Lengths . Hardness Of The Weld Depends Upon Number Of Layers And The Cooling Rate . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite