

Felix 212 AC-DC

Premium Electrode For Joining Dissimilar And Unknown Stainless Steel Compositions Operating At Higher Temperatures .



Special Features

- * Excellent Resistance To Scaling And Oxidation Upto 1200° C .
- * Specially Formulated Flux Provides High Resistance To Hot Cracking .
- * Weld Deposits Are Fully Austenitic .
- * Good Results On Both DC and AC Machines .
- * Stable Arc With Easy Restrike And Self Releasing Slag .

Typical Properties

Tensile Strength	91000 PSI
Yield Strength	61000 PSI
Elongation	35%

Applications

- * Typical Applications Include Valves , Radiant Tubes , Furnace Parts , Heat Shields , Kiln Tubes , Boiler Baffles , Heat Exchangers , Heat Resisting Forged Steels And Heat Treatment Parts Subjected To Service Temperature Of 1200° C .
- * Can Be Used For Welding Stainless Steels Of Similar Composition In Cast And Wrought Forms .

International Specification

AWS/ASME A 5.4 E 310 - 16
ISO 3581: E 25.20 R 26
DIN 8556: E 25.20 R 26

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	50	60	90
Maximum Amperage	75	100	130

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . If Necessary Redry Electrodes At 250° C For One Hour Before Use . DC Reverse Polarity (Electrode +Ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite