

# Felix 221 AC-DC

Premium Low Carbon High Crack Resistance Electrode For Welding Austenitic Stainless Steels . Excellent For Welding 18 Cr-8 Ni Steels .



## Special Features

- \* Low Carbon Content In Felix 221 Eliminates Carbide Precipitation During Welding As Well As In Weld Service .
- \* High Resistance To Weld Metal Porosity .
- \* High Corrosion And Crack Resistance .
- \* Deposits Have Ferrite Content In Range Of 6 - 10 % .
- \* Easy Restrike And Self Releasing Slag .

## Typical Properties

Tensile Strength	75000 PSI
Tensile Strength As Work Hardened	90000 PSI
Yield Strength	53000 PSI
Elongation	37%
Impact Energy ( 150-V/+20°C )	Min 47 J

## Applications

- \* Rutile Coated Electrode for welding 301, 302 , 303 , 304 L, 308 , 308 L , 321 Grade Stainless Steels .
- \* For Welding Stainless Steel Valves, Tanks, Pipes And Lining In Refineries, Oil And Gas, Food, Beverage, Nuclear, Pharmaceutical And Chemical Industries.

## International Specification

AWS /ASME A5.4 E 308L-16  
ISO 3581 E 19.9 L R 32  
BS 2926 -1984 19.9 LR

## Recommended Amperage Settings

Diameter	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	45	70	80
Maximum Amperage	55	70	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° Celcius For One Hour Before Use. DC Reverse Polarity (Electrode +Ve) Or AC.



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite