

# Felix 222 DC (308L-15)

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



## Special Features

- \* Low Carbon Alloyed Wire In Felix 222 Eliminates Carbide Precipitation During Welding As Well As In Weld Service .
- \* Weld Deposits Are Free Of Porosity With Good Resistance To Corrosion .
- \* Basic Coating Of Felix 222 DC ( 308L - 15 ) Gives Highest Crack Resistance .
- \* Excellent Results On DC Reverse Polarity .
- \* Good Results On Heavy Sections Due To High Ductility .

## Typical Properties

Tensile Strength	75000 PSI
Tensile Strength As Work Hardened	90000 PSI
Yield Strength	55000 PSI
Elongation	40%
Impact Energy (150-V/+200 C)	Min 47 J

## Applications

- \* Basic Coated Electrode for welding 301 , 302 , 303 , 304L , 308, 308L , 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-15  
ISO 3581 E 19.9 L B 22

## Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	45	70	80
Maximum Amperage	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° C For One Hour Before Use . DC Reverse Polarity ( Electrode +Ve ) .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite