

# Felix 224 AC-DC

Premium Normal Carbon Content Rutile Electrode For Welding Unstabilized 18 - 8 Austenitic Stainless Steels .



## Special Features

- \* Balanced Ferrite Content Gives Good Corrosion And Crack Resistance .
- \* High Resistance To Weld Metal Porosity With Good Creep Strength .
- \* Deposits Have Ferrite Content In Range Of 4 - 8 % .
- \* Easy Restrike And Self Releasing Slag .

## Typical Properties

Tensile Strength	85000 PSI
Yield Strength	64000 PSI
Elongation	37%

## Applications

- \* Rutile Coated Electrode For Welding Types 301 , 302 , 304 , 305 And 308 Grade Stainless Steels .
- \* For Welding Stainless Steel Valves , Chemical Tanks , Build Up Centrifugal Pumps , Impellers , Shafts , Pipes And Lining In Refineries , Oil And Gas , Food , Beverage , Nuclear , Pharmaceutical And Chemical Industries .

## International Specification

AWS /ASME A5.4 E 308-16

## 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° C For One Hour Before Use . DC Reverse Polarity ( Electrode +Ve ) Or AC .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite