

Felix 225 AC-DC

Premium Electrode For Welding Titanium And Niobium Stabilized 18/8 Stainless Steels .



Special Features

- * Addition Of Columbium As A Stabilizer To Offer High Resistance To Intergranular Corrosion .
- * Controlled Silicon Content For High Resistance To Cracking .
- * All Position Welding With Excellent Results On Both AC And DC Machines .
- * Deposits Have Ferrite Content In Range Of 6 - 10 % .
- * Easy Restrike And Self Releasing Slag .

Typical Properties

Tensile Strength	80000 PSI
Yield Strength	55000 PSI
Elongation	35%

Applications

- * For Welding AISI 347 And AISI 321 Alloys .
- * For Continuous Service At Temperatures Of 350 To 870° C In Chemical Plant , Oil Refinery , Pipeline , Process , Food And Beverage Industry Etc .

International Specification

AWS /ASME A5.4 E 347-16
ISO 3581 E 19.9 Nb R 32
BS 2926 -1984 19.9 Nb R

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) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite