

Felix 252 AC-DC

Premium Rutile Based Electrode for Welding Ti / Nb Stabilized Cr- Ni - Mo Stainless Steel .



Special Features

- * Addition Of Columbium As A Stabilizer To Offer Excellent Resistance To Intergranular Corrosion .
- * Combination Of Molybdenum And Columbium Provides Better Mechanical Properties .
- * Controlled Ferrite Number For Good Resistance To Cracking .
- * All Position Welding With Excellent Results On Both AC And DC Machines .
- * Easy Restrike And Self Releasing Slag .

Typical Properties

Tensile Strength	90000 PSI
Yield Strength	71000 PSI
Elongation	38%

Applications

- * 316 , 316 L , 316 Ti , 316 Cb , 318 , CF-8C , CF-8M Stainless Steels .
- * For Welding Tanks , Valves , Pipelines , Equipment Made Of Ti / Nb Stabilized Cr- Ni- Mo Steels Or Cast Steels Exposed To Highly Corrosive Acids Like Sulphuric Acid , Hydrochloric Acid , Citric Acid , Tartaric Acid Etc .
- * Industries - Chemicals , Food , Textile , Paint , Pharmaceuticals Pulp And Paper .

International Specification

AWS/ASME A 5.4 E 318-16
DIN 8556 : E 19.12.3 Nb R 26
ISO 3581: E 19.12.3 Nb R 32

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	50	70	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 . Redry Electrodes At 200° C For One Hour Before Use . DC Reverse Polarity (Electrode +ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite