Felix 254 AC-DC

Premium Normal Carbon Content Rutile Electrode for Welding Cr- Ni - Mo Austenitic Stainless Steel .

Special Features

* Optimum Ferrite Content Offers Good Resistance To Hot Cracking .
* Austentitic Ferritic Weld Deposits With Ferrite Content Of 4 - 8 % .
* Increased Creep Resistance At High Tempratures Due To Presence Of Molybdenum .
* Good Results On Both AC And DC Machines .
* Smooth Bead Appearance With Easy Slag Removal .

Typical Properties

Tensile Strength	85000 PSI
Yield Strength	59000 PSI
Elongation	38%

Applications

* 316 And 317 Stainless Steels .
* Industries - Chemicals , Petrochemicals , Food , Textile , Brewery , Paint , Pharmaceuticals Pulp And Paper .

International Specification

AWS/ASME A 5.4 E 316-16
ISO 3581: E 19.12.2 R 53

Recommended Amperage Settings

Diameter	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	50	65	80
Maximum Amperage	55	75	90	120

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 150^0 C For One Hour Before Use . AC And DC Reverse Polarity (Electrode +ve) .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

Email : sales@ferrsol.com | Web : www.ferrsol.com