Felix 256 DC (316L-15)

Premium Low Carbon Basic Electrode for Welding Cr-Ni-Mo Austenitic Stainless Steel .

Special Features

* Excellent Resistance To Acid And Corrosion At High Temperature Service Conditions .
* Low Carbon Content Ensures High Resistance To Intercrystalline Corrosion .
* Fast Freezing Flux Coating For Vertical Down Welding .
* High Crack Resistance Due To Adequate Ferrite Content .
* Smooth Bead Appearance With Easy Slag Removal .

Typical Properties

Tensile Strength	81000 PSI
Yield Strength	56000 PSI
Elongation	40%

International Specification

AWS/ASME A 5.4 E 316L-15
DIN 8556: E 19.12.3 LB 42
ISO 3581: E 19.12.3 L B 42

Applications

* 316 And 316 L Stainless Steels .
* For Welding Tanks , Pipes , Digestors , Evaporators , Heat Exchangers , Equipment Made Of Molybdenum Bearing Austenitic Stainless Steels .
* Industries - Chemicals , Petrochemicals , Food , Textile , Brewery , Paint , Pharmaceuticals , Pulp And Paper Etc .

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 . DC Reverse Polarity (Electrode +ve) .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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