Felix 261 AC-DC

Premium Rutile Based High Cr-Ni-Mo Electrode For Welding Dissimilar Steels (Ferritic To Austenitic Steels) .

Special Features

* Molybdenum Content For Higher Corrosion Resistance On Stainless Steels .
* Moisture Resistant Coating Produces Weld Metal Of High Radiographic Integrity .
* Austenitic Weld Metal With A Delta - Ferrite Content Of Approx - 15 % .
* Deposits Are Non Scaling Upto Temprature Of 1050° C .
* Low Spatter With Self Removing Slag Promotes Excellent Weld Appearance .

Typical Properties

Tensile Strength	90000 PSI
Yield Strength	59000 PSI
Elongation	35%

Applications

* Ideal For Welding Of 309 And 309Mo Base Metals And A Wide Range Of 300 And 400 Series Stainless Steels .
* Excellent Results On Joining Of Alloyed And Non - Alloyed Dissimilar Ferrous Metal Combinations And Welding Of Acid Resisting Clad Steels .

International Specification

AWS/ASME A 5.4 E 309 LMo-16
ISO 3581-A : E 23 12 2 LR 32
DIN 8556: E 23.13.2 LR 26

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	50	60	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 . DC Reverse Polarity (Electrode +Ve) Or AC .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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