

Felix 263 AC-DC

Premium Normal Carbon Content Rutile Electrode For Welding Of Heat Resistant 22Cr/12Ni Austenitic Stainless Steels To Mild Steels And Low Alloyed Steels .



Special Features

- * High Efficiency Electrode With Austenitic - Ferritic Stainless Steel Deposits .
- * Weld Deposits With Good Mechanical Properties And Corrosion Resistance At High Temperatures Upto 1100° C .
- * Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- * Excellent Scaling Resistance .

Typical Properties

Tensile Strength	87000 PSI
Yield Strength	60000 PSI
Elongation	38%

Applications

- * For Welding Of Tanks , Mufflers , Corrosion And Heat Resistant Coatings Over Carbon Steel , Welding Similar Type Austenitic Stainless Steels , Steels to Stainless Steels , Buffer Layers on Low Carbon / Low Alloy Steels Prior to Hardfacing Etc .

International Specification

AWS/ASME A 5.4 E 309 -16

DIN 8556 : E 23 12 R 23

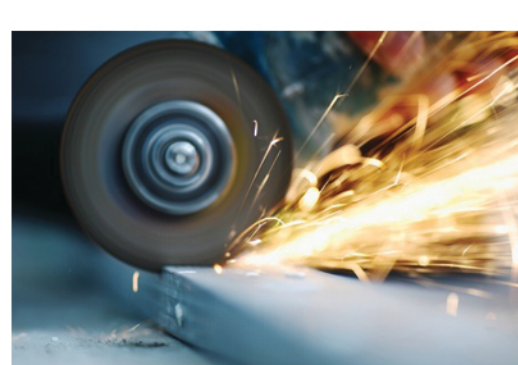
IS 5206 : E 23 12 R 26

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 200° C For One Hour Before Use . DC Reverse Polarity (Electrode +ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite