Felix 268 AC-DC

Premium Low Carbon Electrode With Columbium for Welding Heat Resistant Ferritic Chrome Steels And Austentic Cr-Ni Steels .

Special Features

* Addition Of Columbium As A Stabilizer Offers Good Results Where Resistance To Corrosion At High Temperature Is Required .
* Weld Deposits Are Free Of Porosity And Exhibits Good Polish As Base Material .
* Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
* Addition Of Columbium Provides Better Mechanical Properties During Operations At Higher Service Tempratures .

Typical Properties

Tensile Strength	95000 PSI
Yield Strength	71000 PSI
Elongation	30%

Applications

* For Welding Of AISI 301 , 302 , 304 , 308 , 309 , 347, 321 To Itself And With Mild Steel And Low Alloy Steel .
* Industries - Nuclear , Aerospace , Refinery , Dairy , Chemical , Petrochemicals , Textile Etc .

International Specification

AWS/ASME A 5.4 E 309 Cb-16
EN: E23 12 Nb R 32
ISO 3581: E23 12 Nb R 32

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	50	65	90
Maximum Amperage	75	95	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

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