

Felix 287 DC (410-15)

Premium 13% Cr Basic Electrode For Welding AISI 403 , 405 , 410 , 420 Steels .



Special Features

- * Good Corrosion Resistance In Aequous Conditions And Against Sulphuric Gases .
- * Recommended Preheat And Postheat Weld Treatment Except Thin Sections .
- * Martensitic Stainless Steel Deposits Which Are Non - Scaling Up To 850° C .
- * Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- * Smooth Weld Beads With Good Operator Appeal .

Typical Properties

Tensile Strength	75000 PSI
Yield Strength	58000 PSI
Elongation	21%

Applications

- * Typical Applications Are Valve Seats , Hydroelectric Turbine Fans , Propeller Shafts , Pump Rotors , Gas Turbine Parts In Power Generation , Offshore , Chemical , Oil And Petrochemical Industries .
- * Used For Overlaying Mild And Low Alloy Steels For Resistance To Corosion, Erosion And Abrasion.

International Specification

AWS/ASME A 5.4 E 410-15

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	45	70	100
Maximum Amperage	70	110	140

Welding Techniques

Clean Weld Area . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . If Necessary Redry Electrodes At 300° C For One Hour Before Use . Preheat At 100-150° C For Thick Components . Post Weld Heat Treatment At 580-620° C DC Reverse Polarity (Electrode +Ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite