

Felix 289 DC (410NiMo-15)

Premium Lime Titania Type Basic Electrode For Welding AISI 403 , 405 , 410 , 420 Steels And 13% Cr - Ni Cast Steels .



Special Features

- * Good Corrosion Resistance In Aequous Conditions .
- * Balanced Addition Of Alloying Elements Ensures High Ductility And Improved Physical Properties .
- * Recommended Preheat And Postheat Weld Traetment Except Thin Sections .
- * Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- * Smooth Weld Beads With Good Operator Appeal .

Typical Properties

Tensile Strength	122000 PSI
Yield Strength	100000 PSI
Elongation	18%

Applications

- * Typical Applications Are Hydraulic Turbines , Valve Bodies , High Pressure Pipelines , Impellers , Compressor Cones In Power Generation , Offshore , Chemical , Oil And Petrochemical Industries .

International Specification

AWS/ASME A 5.4 E 410NiMo-15

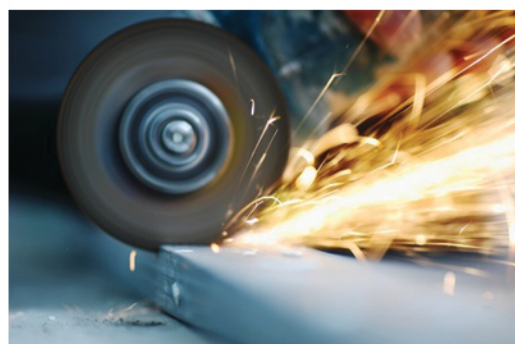
- * Can Be Used For Overlaying Mild And Low Alloy Steels .

Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	55	70	100
Maximum Amperage	80	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° Celsius . DC Reverse Polarity (Electrode +Ve) .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite