

# Felix 294 DC (430-15)

Premium Basic Coated Electrode For Welding 17% Cr Alloyed Steel .



## Special Features

- \* Good Corrosion Resistance And Heat And Oxidation Resistance Up To 1500° F.
- \* Excellent Resistance To Citric Acid , Nitric Acid And Sulfur Gases .
- \* Weld Deposits Are Free Of Porosity .
- \* Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- \* Smooth Weld Beads With Good Operator Appeal .

## Typical Properties

Tensile Strength	85000 PSI
Yield Strength	63000 PSI
Elongation	24%
Impact Energy ISO-V (J) 200 C	Min 47 J

## Applications

- \* For Welding AISI 430 Grade Ferritic Martensitic Steels And Steel Castings . Typical Applications Nitric Acid Plant Equipment , Oil Refinery Equipment , Furnace Combustion Chambers , Hardfacing Exhaust Valves , Pump Parts Etc .

## International Specification

AWS /ASME A 5.4 E 430-15  
ISO 3581 E 17 B 130 36 X  
EN 1600 E 17 B 43

## 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 . 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 . If Necessary Redry Electrodes At 300° C For One Hour Before . Use DC Reverse Polarity ( Electrode +Ve ) .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite