

# Felix 725 AC-DC

Premium Basic Coated Work Hardening Electrode For Wear Caused By Heavy Shock And Impact .



## Special Features

- \* Ductile And Crack Free Weld Deposits .
- \* Hardness Increases In Service By Cold Working And Can Also Be Enhanced By Peening .
- \* Easy Slag Removal With Excellent Weld Appearance .
- \* Excellent Performance On Both AC And DC Machines .

## Typical Properties

Hardness As Welded	18-20 RC
Hardness After Work Hardening	40-44 RC

## Applications

- \* For Hardfacing And Repair Welding Of Wearing Parts Made Of Austenitic Manganese Steels Such As Crusher Jaw Plates , Excavator Teeth , Earthmoving Equipment , Beating Arms , Pulverizing Hammers , Shovel Track Pads , Wear Plates , Crusher Cones Etc .

## International Specifications

DIN 8555 : E 7 UM - 200 KP

## Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	120	180
Maximum Amperage	140	160	230

## Welding Techniques

Clean Weld Area . Stringer Beads Or Weaves Can Be Used With Short Arc Lengths . Minimal Slag Is Produced And Can Be Overwelded Without Prior Removal . Best Results DC Reverse Polarity .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite