

Felix 734 AC-DC

Premium Rutile Coated Hardfacing Electrode With High Toughness And Resistance to Moderate Abrasion .



Special Features

- * Air Hardening Electrode Offering High Resistance To Compressive Loads .
- * Very Tough Alloy For Underlayments , Build Up And Buffering .
- * Easy Slag Removal With Excellent Weld Appearance .
- * Excellent Performance On Both AC And DC Machines .

Typical Properties

Hardness 32-35 HRC

Applications

- * Good Results On Crane Wheels , Rollers , Drive Sprockets , Conveyor Parts , Couplings , Gears , Shafts , Cams , Axles , Pulleys , Track Rollers Etc .

International Specification

DIN 8555 : E1 UM-350

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	70	90	120	150
Maximum Amperage	90	120	140	180

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