

Felix 735 AC-DC

Rutile Coated Hardfacing Electrode With High Resistance To Severe Impact And Moderate Abrasion .



Special Features

- * Air Hardening Electrode Multi Alloyed Deposits Offering High Resistance To Compressive Loads .
- * Very Tough Alloy For Underlayments , Build Up And Buffering .
- * Smooth Running Electrode For 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 , Hammers , Rollers , Excavators , Drive Sprockets , Couplings , Conveyor Parts , Gear Teeth , Shafts , Cams , Axles , Pulleys , Carbon - Alloyed Rails , Track Rollers Etc .

International Specifications

Proprietary Product

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