

Felix 739 AC-DC

Premium High Deposition Electrode For Plain & Alloyed Manganese Steels .



Special Features

- * High Deposition Work Hardening Electrode With High Ductility .
- * Immediate Increase In Hardness During Operation .
- * Good Resistance To Impact Due To High Toughness .
- * Smooth Running Electrode With Excellent Bead Appearance & Easily Removable Slag .

Typical Properties

Hardness As Welded 21 - 25 RC
Hardness After Work Hardening 42 - 45 RC

Applications

- * For Building Up , Surfacing And Joining Of Manganese Steels . Typical Applications Are Excavator Teeth , Crusher Plates , Rails , Manganese Steel Rails , Bucket Teeth , Pulverising Hammers Etc .

International Specification

Proprietary Product

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	80	100	160
Maximum Amperage	120	140	200

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 . Pre Heating Not Advised For 14% Manganese Steels .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite