

Felix 745 AC-DC

Premium Multi Layer Hardfacing Electrode With Good Resistance To Abrasion And Moderate Impact .



Special Features

- * Basic Hardfacing Electrode With Good Combination Of High Hardness And Toughness .
- * The Deposit Is Not Machinable But Can Be Ground If Necessary .
- * Multi Layers Can Be Applied Without Use Of Buffer Layer .
- * All Position With Pass On Pass Welding Possible Without Slag Removal .

Typical Properties

Hardness 56 - 58 HRC
Wear Coefficient 2.20 %

Applications

- * Typical Application Include Crusher Jaws , Crusher Hammers , Conveyor Screws , Excavators Parts , Dipper Teeth , Mill Hammers , Drill Bits , Rebound Crushers , Chutes , Rolling Crushers , Conveyor Buckets , Grader Blades , Coal Crusher Segments And Many More Operating In Sand , Clay , Cement And Coal .

International Specifications

DIN 8555 : E6-UM-60

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 . Full Hardness Can Be Achieved With Maximum 3 Layers . Minimal Slag Is Produced And Can Be Overwelded Without Prior Removal . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite