

Felix 752 AC-DC

Premium Air Hardening Electrode With Best In Class Resistance To Severe Abrasion .



Special Features

- * Extremely High Resistance To Mineral Abrasion And Metal To Metal Wear .
- * Soft Arc With Excellent Slag Detachability .
- * The Deposit Is Not Machinable But Can Be Ground If Necessary .
- * Martensitic Cast Iron Structure Extremely Resistant To Scratching . Cross Crack Stress Relieving Is Normal .

Typical Properties

Hardness 62-66 HRC

Applications

- * Typical Application Include Excavator Teeth , Screw Conveyors , Screw Blades , Oil Expeller Worms , Pump And Crusher Parts , Muller Tyres , Plough Shares Etc .

International Specifications

DIN 8555 : E6-UM-60P

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	120	150
Maximum Amperage	130	150	180

Welding Techniques

Clean Weld Area . Stringer Beads Or Weaves Can Be Used With Short Arc Lengths . Recommended Use Of Felix Durabond XS If No Of Passes Increases Than Two Minimal Slag Is Produced And Can Be Overwelded Without Prior Removal . Best Results DC Straight Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite