

Felix 770 AC-DC

Premium Multi Carbide High Hardness Electrode For High Temperature Abrasion .



Special Features

- * Special Flux Formulation For Hardness Retention Till 650° C .
- * High Deposition Rates With Excellent Abrasion Resistance On Carbon Steels , Low Alloy And Manganese Steels .
- * The Deposit Is Not Machinable But Can Be Ground If Necessary .
- * Good Resistance To Light And Moderate Impact .

Typical Properties

Hardness 62 - 64 HRC
Hardness At 650° C 46 - 48 HRC

Applications

- * Typical Application Include Coal Burner Nozzles , Furnace Parts , Blast Furnace Bells , Sinter Plant Disintegrators , Conveyor Screws , Clinker Grinders , Ore Crushers , Blast Furnace Parts , Steam Valve Flanges , Ore Breaker Teeth Etc .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	120	200
Maximum Amperage	130	150	240

Welding Techniques

Clean Weld Area . Stringer Beads Or Minimal Weaves Can Be Used With Short Arc Lengths . 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