

# Felix 779 AC-DC

Premium Complex Carbide Electrode For High Resistance To Coarse Abrasion .



## Special Features

- \* High Deposition Rates With Excellent Abrasion Resistance At Temperatures Upto 650° C .
- \* The Deposit Is Not Machinable But Can Be Ground If Necessary .
- \* Good Resistance To Impact .
- \* Excellent Restrike Properties With Good Arc Control .

## Typical Properties

Hardness 58-62 HRC  
Wear Coefficient 2 %

## International Specifications

Proprietary Product

## Applications

- \* Typical Application Include Pug Mill Paddles , Augers , Cement Press Screws , Asphalt Mixer Paddles , Brick Press Screws , Impellers , Dredger Parts , Refractory Press Screws And Parts Subjected To High Abrasion And Metal To Metal Wear On Carbon Steels , Manganese Steels And Alloy Steels .
- \* Excellent Results For Crusher Applications In Mining , Construction And Cement Industry .

## Recommended Amperage Settings

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

## Welding Techniques

Clean Weld Area . Stringer Beads Or Minimal Weaves Can Be Used With Short Arc Lengths . Recommended Use Of Felix 266 As Buffer Layer . Deposit Felix 842 As Buffer Layer For Cast Iron . 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