Felix 833 AC-DC

98 % Nickel Soft , Highly Machinable , High Strength Electorde For Joining Cast Iron To Cast Iron To Steel .

Special Features

* Heat Affected Zone And Weld Metal Easily Machinable .
* High Nickel Content Provides Resistance To Cracking With Excellent Machinability .
* Specially Fromulated Flux Produce Porus Free Welds .
* Non Coductive Coating Produces Strong Arc Ideally For Dirty Contaminated Cast Irons .
* Easy Arc Striking And Restriking , Stable Arc , Smooth Bead Surface .

Typical Properties

Tensile Strength	53000 PSI
Yield Strength	36000 PSI
Hardness	150 Brinell

International Specifications

AWS/ASME A 5.15 : E NiCI
DIN 8573 : E Ni BG 11

Applications

* Electrode For Welding Cast Iron With Lamellar Graphite , White And Black Heart Malleable And Nodular Cast Iron . Applications Include Machine Bases , Pump Casings , Gear Boxes , Transmission Mountings , Engine Blocks Etc .
* Used Also For Joining Cast Iron To Steel .

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	60	90	110
Maximum Amperage	90	120	140

Welding Techniques

Remove All Rust , Scale And Scale From The Surface To Be Welded . Adjust Amperage Within Recommended Range And Deposit Electrode , Maintaining A Short To Medium Arc Length . Tilt The Electrode The Direction Of Travel . Use Stringer Bead Or Moderate Weave Technique And Back-Whip All Craters .
Use Straight Polarity On DC / AC .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

Email : sales@ferrsol.com | Web : www.ferrsol.com