

Felix 401 DC

Premium Electrode For Joining And Building Up Pure Copper .



Special Features

- * High Quality Dense Deposits Exhibiting Good Corrosion Resistance And High Electrical & Thermal Conductivity .
- * Can Be Used For Joining Dissimilar Grades Of Pure And Alloyed Copper .
- * Stable Arc With Easy Slag Removal .
- * Ideal For Surfacing Welds On Steels .

Typical Properties

Tensile Strength	32000 PSI
Hardness	Brinell 50
Elongation	32%

Applications

- * Ideal For Welding Of Oxygen Free Deoxidized Copper , Copper Castings , Copper Connectors , Bus Bars , Steel Mills Electrode Holders , Heater Elements , Electrical Conductive Joints Etc .

International Specifications

AWS/ASME A 5.6 E Cu
DIN 1733 : EL-CuMn2

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	40	70	100
Maximum Amperage	70	100	130

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . Preheating At 450 - 650° C Is Required For Heavier Sections . DC Reverse Polarity (Electrode +Ve) .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite