

# Felix 410 DC

Premium Tin Bronze Electrode For Joining And Surfacing  
Copper Alloys .



## Special Features

- \* A Multipurpose Electrode For Joining Copper Base Alloys Not Only To Itself But Also To Steels And Cast Iron .
- \* Addition Of Tin For Harder And Wear Resistant Deposits .
- \* Stable Arc With Easy Slag Removal .
- \* Dense Porosity Free Weld Deposits With High Crack Resistance .

## Typical Properties

Tensile Strength	41000 PSI
Hardness	Brinell 110
Elongation	30 %

## Applications

- \* Cams , Pumps , Values , Pulleys , Pistons , Housings , Impellers Bushings , Axle Stops , Propellers , Mixer Arms , Feed Screws , Shaft And Sheaves , Bearing Surfaces , Conveyor Guides , Crosshead Slides Drive Sprockets Etc .

## International Specifications

AWS/ASME A 5.6 E CuSn-C  
DIN 1733 : EL-CuSn8

## Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	80	100
Maximum Amperage	110	140

## 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