Felix 622 (E 8018-B1)

Premium Basic Coated Electrode For Welding 0.5 % Cr- 0.5 %Mo Creep Resistant Steels.

Special Features

* Special Formulated Coating Provides Weld Deposits With Excellent Crack Resistance .
* Weld Metal Is Chromium Molybdenum Alloyed With Operating Tempratures Upto 550° C .
* High Recovery Electrode With Good Arc Stability , Low Spatters And Easily Removable Slag .
* Low Moisture Reabsorption Quality Prevents Hydrogen Cracking And Eliminates Starting Porosity .

Typical Properties

Tensile Strength	Min 83000 PSI
Yield Strength	Min 67000 PSI
Elongation	Min 24 %
ISO - V (J) - 20° C	Min 80

International Specifications

AWS/ASME A5.5: E 8018 - B1

Applications

* For Welding Of 0.5% Cr- 0.5% Mo Heat Resistant Steel Used For High Temprature And High Preasuure Boilers And Assosciated Tubing Applications .
* Power Generation, Petrochemical , Pressure Vessels , Process Piping , High Temprature Chemical And Oil Refining Industries .

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Length	350	350	350	450
Minimum Amperage	60	90	130	180
Maximum Amperage	85	130	180	230

Welding Techniques

Clean Weld Area . Re-Dry The Electrode At 350° C For 1 Hour . Preheating At 150 - 300° C Is Required Specially For Hardenable Steels To Prevent The Formation Of A Hard Heat-Affected Zone . Preffered DC Reverse Polarity .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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