

Felix 624 (E 8015-B6)

Premium Basic Coated Low Hydrogen Electrode For Welding
5% Cr -0.5 %Mo Creep Resistant Steels .



Special Features

- * Special Formulation For Good Corrosion Resistance In Superheated Steam , Hydrogen Gas And Crude Oils With High Sulphur Content .
- * Weld Metal Is Chromium Molybdenum Alloyed With Operating Temperatures Upto 600° C .
- * High Recovery Electrode With Good Arc Stability , Low Spatters And Easily Removable Slag .
- * Low Moisture Reabsorption Quality And Prevents Hydrogen Cracking And Eliminates Starting Porosity .

Typical Properties

Tensile Strength	Min 87000 PSI
Yield Strength	Min 67000 PSI
Elongation	Min 23 %
ISO - V (J) + 20° C	Min 100

Applications

- * For Welding Of 5% Cr -0.5 % Mo Heat Resistant Steel Used For Boilers , Associated Tubing , Pressure Vessels , Heat Exchangers Etc . In Power Generation , Petrochemical In Chemical And Oil Refining Industries .

International Specifications

AWS/ASME A5.5 : E8015 - B6

Recommended Amperage Settings

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

Welding Techniques

Clean Weld Area . Re-Dry The Electrode At 350° C For 1 Hour . Preheating At 150 - 300° C Is Required .
Preffered DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite