Felix 628 (E 8013-G)

Premium Rutile Coated Electrode For Welding Of Molybedenum Alloyed Creep Resistant Steels .

Special Features

* Special Formulated Coating Provides Weld Deposits With Excellent Crack Resistance .
* Weld Metal Is Molybdenum Alloyed With Operating Tempratures Upto 550° C .
* Can Be Heat Treated And Case Hardened .
* Porosity Free Welds With Good Arc Stability , Low Spatters And Easily Removable Slag .

Typical Properties

Tensile Strength	Min 82000 PSI
Yield Strength	Min 70000 PSI
Elongation	Min 24 %
ISO - V (J) + 20° C	Min 50

Applications

* For Welding Of Mo Alloyed Heat Resistant Steel Used For Boiler Plates , Pressure Vessels , Tube Steels , Pipings Etc . In Power Generation , Petrochemical , High Temprature Chemical And Oil Refining Industries .

International Specifications

AWS/ASME A5.5: E 8013 - G

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 . Preheating , Interpass Temprature And Post Weld Treatment Depending On Base Metal . Arc length Should be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . Preffered DC Reverse Polarity .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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