

Felix 635 (E 9018-B3)

Premium High Strength Basic Coated Electrode For Welding
2.25 Cr 1 Mo Low Alloy Steels .



Special Features

- * Special Formulation Coating To Resist Moisture Pick Up Under Conditions Of High Heat And Humidity .
- * High Iron Powder Coating Increases Working Efficiency Making It Suitable For Welding Thick Main Pipes And Steel Castings .
- * 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 90000 PSI
Yield Strength	Min 60000 PSI
Elongation	Min 22 %
ISO - V (J) - 30° C	Min 70

International Specifications

AWS/ASME A 5.5 E9018 - B3
EN 1599: E CrMo 2 B 32

Applications

- * For Welding 2.25% Cr-1% Mo Steel Subjected To Elevated Temperatures As Found In Power Piping And Boiler Industries .
- * Power Generation , Petrochemical , Pressure Vessels , Process Piping , High Temperature 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 . Preferred DC Reverse Polarity.



FELIX
Innovative Metallurgy

A Quality Product From Ferrite