Felix-665 DC(AWS-8018C1)

Premium Basic Coated Iron Powder Low Hydrogen Type Electrode For Applications Of 2 % Nickel Deposits At Low Tempratures .

Special Features

* Good Impact Properties At Tempratures Upto -75° C .
* Iron Powder Electrode With Recovery As High As 120 % .
* Low Hydrogen X - Ray Quality Weld Deposits With High Metallurgical Purity .
* Quiet Stable Arc With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

Typical Properties

Tensile Strength	91000 PSI
Yield Strength	79000 PSI
Elongation	26%
Impact Energy ISO-V	121 J At -59° C

Applications

* Typical Applications Include Nickel Bearing Steels For Low Temprature Applications , Pipelines And Tanks For Liquified Gases , Ship Building , Chemical Equipments And Low Temprature Fabrications Where Good Notch Toughness Is Required .

International Specifications

AWS/ASME A5.5: E8018-C1

Recommended Amperage Settings

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

Welding Techniques

Clean Weld Area . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 350° C For 2 Hour . Stringer Beads Or Weaving Technique Can Be Used . Maintain Short Arc For Best Mechanical Properties . For Best Results DC Reverse Polarity .

FELIX
Innovative Metallurgy

A Quality Product From Ferrite

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