

# Felix 698 (AWS-12018G)

Premium Basic Coated Very Low Hydrogen Electrode For Welding Of Low Alloy High Tensile Steels .



## Special Features

- \* Balanced Alloying Of Manganese , Chromium , Nickel And Molybdenum For Exceptional Mechanical Properties .
- \* Excellent Impact Values At Sub Zero Temperatures .
- \* X - Ray Quality Weld Deposits With High Metallurgical Purity .
- \* All Position Welding With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

## Typical Properties

Tensile Strength	138000 PSI
Yield Strength	123000 PSI
Elongation	20%
Impact Energy ISO-V	80 J At -40° C

## Applications

- \* Typical Applications Include Pressure Vessels , Heavy Machinery , Penstocks , Steel Castings , High Pressure Steam Pipes , Earth Moving Equipment Parts , Cranes , Shipbuilding And Fabrication Of Quenched And Tempered Low Alloy High Strength Steels .

## International Specifications

AWS/ASME A5.5: E12018-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 . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 350° C For 1 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