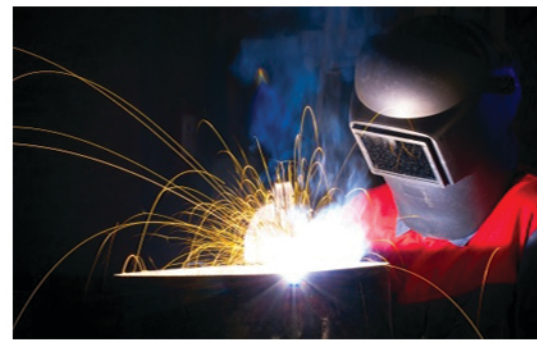


Felix 788 AC-DC

Premium Basic Coated Electrode For Building Up Hot Forging Dies .



Special Features

- * High Resistance To Deformation At High Temperatures .
- * The Deposits Are Dense And Are Free Of Porosity .
- * Excellent Resistance To Hot Cracking .
- * Smooth Running Electrode With Excellent Bead Appearance .

Typical Properties

Hardness	38 - 43 HRC
Tensile Strength	105000 PSI
Elongation	35 - 37%

Applications

- * Ideal For Building-Up And Repair Of Hot Forging Tools , Moulds , Flanges , Distributor Pins , Drop Forging Dies , Hard Facing Of Saddle Tracks , Dies For The Hot - Production Of Screws Tools Etc . Good Results On Joining Of High Tensile Steels .

International Specifications

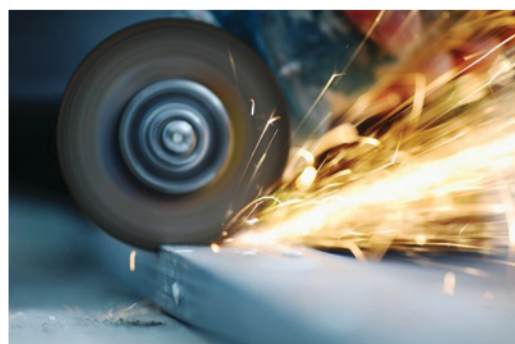
Proprietary Product

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	80	110	140
Maximum Amperage	120	150	180

Welding Techniques

Clean Weld Area . Pre - Heat Job To 300° C - 400° C And Maintain Throughout Welding . Maintain Short Gap And Clean Slag Between Passes . Air-Cool The Job To 200° C To Develop Uniform Hardness . Temper For 12-16 Hours At 400° C - 500° C . Remove Into Still Air And Cool . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite