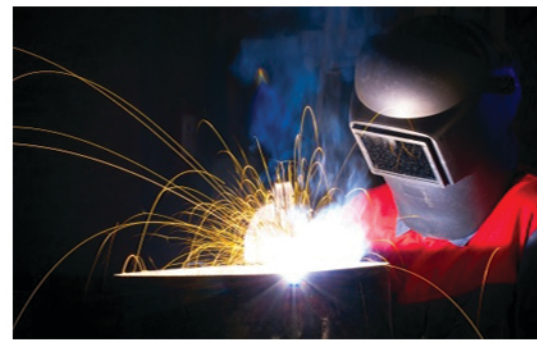


Felix 797 AC-DC

Premium Iron Based Chrome - Nickel - Moly - Vanadium Alloy
For Flood Welding Hot Forging Dies .



Special Features

- * Unique Chemistry Results In High Elongation , High Tensile Strength With Unmatched Impact Qualities .
- * The Deposits Are Dense And Are Free Of Porosity .
- * High Resistance To Deformation At High Temperatures .
- * Smooth Running Electrode With Excellent Bead Appearance .

Typical Properties

Hardness	35-40 HRC
Tensile Strength	165000 PSI
Elongation	18%

Applications

- * Ideal For Building - Up And Repair Of Hot Forging Tools , Hammer Dies , Rams , Moulds , 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 350° C - 450° 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 500° C - 600° C . Remove Into Still Air And Cool . Use AC Or DC Reverse Polarity .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite