

# Felix 608 (E 7018-A1)

Premium Basic Coated Electrode For Welding Of 0.5 % Mo Alloyed Creep Resistant Steels .



## Special Features

- \* Special Formulated Low Hydrogen Coating Provides Weld Deposits With Excellent Crack Resistance And High Ductility .
- \* Weld Metal Is Molybdenum Alloyed With Operating Temperatures Upto 550° C .
- \* Recovery As High As 110% Due To Addition Of Iron Powder .
- \* Porosity Free Welds With Good Arc Stability , Low Spatters And Easily Removable Slag .

## Typical Properties

Tensile Strength	Min 81000 PSI
Yield Strength	Min 72000 PSI
Elongation	Min 24 %
ISO - V (J) - 40° C	Min 60

## Applications

- \* For Welding Of Molybdenum Alloyed Heat Resistant Steel , Creep Resistant Steels , Medium And High Tensile Alloy Steels Used For Boiler , Pressure Vessels , Tube Steels , Piping Heavy Fabrication , Storage Tanks Etc .

## International Specifications

AWS/ASME A5.5 : E7018 - A1

## 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 . Preheating , Interpass Temperature And Post Weld Treatment Depending On Base Metal . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . Preferred DC Reverse Polarity .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite