

# Felix 220 AC-DC

Premium Low Carbon High Crack Resistance Electrode For Welding 18 Cr - 8 Ni Austenitic Stainless Steels .



## Special Features

- \* Low Carbon Alloyed Wire In Felix 220 Eliminates Carbide Precipitation During Welding As Well As In Weld Service .
- \* Weld Deposits Are Free Of Porosity With Good Resistance To Corrosion .
- \* Felix 220 AC-DC Gives Highest Crack Resistance .
- \* Good Results On Heavy Sections Due To High Ductility .

## Typical Properties

Tensile Strength	70000 PSI
Tensile Strength As Work Hardened	86000 PSI
Yield Strength	52000 PSI
Elongation	38%

## Applications

- \* For Welding 301 , 302 , 303 , 304L , 308 , 308L , 321 Grade Stainless Steels .
- \* For Welding Stainless Steel Valves , Tanks , Pipes And Lining In Refineries , Oil And Gas , Food , Beverage , Nuclear , Pharmaceutical And Chemical Industries .

## International Specification

AWS / ASME A5.4 E 308L-16  
ISO 3581 E 19.9 L R 32

## Recommended Amperage Settings

Diameter	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	45	70	80
Maximum Amperage	70	100	130

## Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Arc Length Should Be Kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . If Necessary Redry Electrodes At 250° C For One Hour Before Use . DC Reverse Polarity ( Electrode +Ve ) .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite