

Felix 223 AC-DC

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



Special Features

- * Low Carbon Content In Felix 223 Eliminates Carbide Precipitation During Welding As Well As Weld Service .
- * High Resistance To Weld Metal Porosity .
- * High Corrosion And Crack Resistance .
- * Deposits Have Ferrite Content In Range Of 6-10 % .
- * Easy Restrike And Self Releasing Slag .

Typical Properties

Tensile Strength	78000 PSI
As Work Hardened	95000 PSI
Yield Strength	53000 PSI
Elongation	40%

Applications

- * For Welding Stainless Steel Valves , Tanks , Pipes And Lining In Refineries, Oil And Gas, Food, Beverage, Nuclear, Pharmaceutical And Chemical Industries .
Can Be Used For Welding Stainless Steel To Low Alloy Steel .

International Specifications

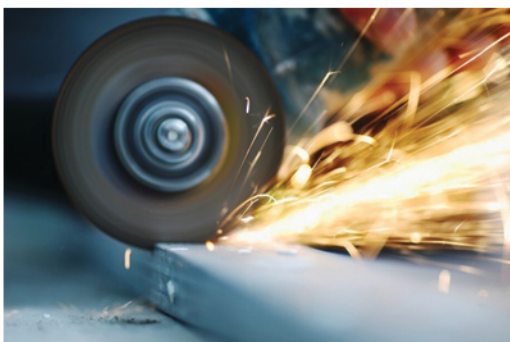
Proprietary Product

Recommended Amperage Settings

Diameter(mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	45	70	80
Maximum Amperage	55	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 Deg Celcius For One Hour Before Use .DC Reverse Polarity (Electrode +Ve) Or AC . .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite