

Felix 265 AC-DC

Premium Low Carbon Electrode For Welding Heat Resistant Ferritic Chrome Steels And Austenitic Cr-Ni Steels .



Special Features

- * Excellent Heat And Crack Resistance .
- * Weld Deposits Are Free Of Porosity .
- * Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- * Excellent Scaling Resistance .
- * Low Carbon Helps Eliminary Carbon Precipitation At High Temperatures .

Typical Properties

Tensile Strength	78000 PSI
Tensile Strength As Work Hardened	105000 PSI
Yield Strength	73000 PSI
Elongation	32%
Impact Energy (150-V/+20° C)	Min 47 J

Applications

- * For Welding Of Similar Type Austentic Stainless Steels , Steels To Stainless Steels , Buffer Layers On Low Carbon / Low Alloy Steels Prior To Build Up .
- * Industries - Refinery , Chemical , Petrochemicals , Textile Etc .

International Specification

AWS/ASME A 5.4 E 309L -16
EN : E23 12 LR 32
ISO 3581: E23 12 LR 32

Recommended Amperage Settings

Diameter	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	50	65	80
Maximum Amperage	55	75	90	120

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 . Redry Electrodes At 200° C For One Hour Before Use . DC Reverse Polarity (Electrode +ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite