

Felix 830 AC-DC

Premium Graphite-Basic Coating Electrode For Cold Welding Of Grey , Malleable And Nodular Cast Iron .



Special Features

- * Ideal For Repairs On All Types Of Cast Iron Especially Where Soft Deposits Are Important .
- * The Weld Metal Gives An Excellent Colour Match With The Casting .
- * Specially Formulated Flux For Deposits Free Of Porosity .
- * Smoother Weld Deposit With Easy Slag Removal And Neat Surface Finish .

Typical Properties

Tensile Strength	56000 PSI
Yield Strength	41000 PSI
Hardness	150-165 Brinell

Applications

- * Ideal For Repairs On Engine Blocks, Heads, Housings, Machine Bases Transmissions And Gears . Can Also Be Used For Build-Up And Joining Steel To Cast Iron .
- * Excellent For Rectification Of Casting Defects On New Castings .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	60	90	110
Maximum Amperage	90	120	140

Welding Techniques

Remove All Rust , Scale And Scale From The Surface To Be Welded . Adjust Amperage Within Recommended Range And Deposit Electrode , Maintaining A Short To Medium Arc Length .Tilt The Electrode In The Direction Of Travel . Use Stringer Bead Or Moderate Weave Technique And Back-Whip All Craters . Good Results On Both AC And DC Machines .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite