

Felix 831 AC-DC

Highly Machinable , High Strength Electrode For Joining
Cast Iron To Cast Iron To Steel With Pure Nickel Core Wire.



Special Features

- * Heat Affected Zone And Weld Metal Easily Machinable .
- * High Nickel Content Provides Resistance To Cracking With Excellent Machinability .
- * Specially Formulated Flux Produce Porus Free Welds .
- * Non Conductive Coating Produces Strong Arc Ideally For Dirty Contaminated Cast Irons .
- * Easy Arc Striking And Restriking , Stable Arc , Smooth Bead Surface .

Typical Properties

Tensile Strength	50000 PSI
Yield Strength	35000 PSI
Hardness	160 Brinell

Applications

- * Electrode For Welding Cast Iron With Lamellar Graphite , White And Black Heart Malleable And Nodular Cast Iron . Applications Include Machine Bases , Pump Casings , Gear Boxes , Transmission Mountings , Engine Blocks Etc .
- * Used Also For Joining Cast Iron To Steel .

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