

# Felix 834 AC-DC

98 % Nickel Soft , Highly Machinable , High Strength Electrode  
For Joining Cast Iron To Cast Iron To Steel .



## 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 | 53000 PSI   |
| Yield Strength   | 36000 PSI   |
| Hardness         | 150 Brinell |

## International Specifications

AWS/ASME A 5.15 : E NiCl  
DIN 8573 : E Ni BG 11

## 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 .

## 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 The Direction Of Travel . Use Stringer Bead Or Moderate Weave Technique And Back-Whip All Craters .  
Use Straight Polarity On DC / AC .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite