

Felix 835 AC-DC

Premium High-Nickel Graphite-Coated Cast Iron Electrode For The Filing Of Casting Defects .



Special Features

- * Felix 835 Produces A Highly Fluid Molten Pool With Excellent Wetting Properties For The Filing Of Casting Defects .
- * Special Formulation Of Felix 835 Prevents Formation Of Carbides In The Fusion Zone (FZ) And Martensite In Both The FZ And Heat Affected Zone (HAZ) .
- * Deposits Of Felix 835 Produces High-Nickel Fusion Zones Which Is Soft And Machinable But Have Adequate Tensile Strength, Ductility And Fatigue Strength .
- * Felix 835 Produces Slag Confirming To “Slag-Over-Slag” Technique Highly Suitable For Welding Deep Areas Where Slag Removal Is A Problem .
- * Close Color Match .

Typical Properties

Tensile Strength	54000 PSI
Yield Strength	36000 PSI
Hardness	150 Brinell

Applications

- * Repair And Reclamation Of Automotive Engine Blocks, Cylinder Heads, Differential Housings, Gear Boxes, Pump And Machine Housings, Pulleys Etc .
- * Suitable For Joining Gray Iron, Ductile Iron, Compacted Graphite Iron, Malleable Iron And Various Alloyed Irons To Themselves And To Steels And Nickel Alloys .

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



FELIX
Innovative Metallurgy

A Quality Product From Ferrite