

# Felix 950 AC-DC

Premium Quality High Hardness Electrode For Most Tool Steels With Excellent Crack Resistance .



## Special Features

- \* Work Hardening Deposits of Felix 950 AC-DC Are Extremely High Resistant To Abrasion And Metal To Metal Erosion .
- \* Special Alloying Chemistry Enables Multiple Layers With This Electrode For High Buildups .
- \* Smooth And Spatter Free Operation Providing High Quality Porosity Free Welds .

## Typical Properties

Hardness	46 - 48 HRC
As Work Hardened	55 - 58 HRC

## International Specifications

Proprietary Modification

## Applications

- \* Used Specially On Tools And Dies Of The 5% Chromium Type And The High Carbon High Chromium Types . Typical Application Include Extrusion Dies , Blanking Dies , Coining Dies , Forming Dies , Cutting Dies , Shears And Other Cutting Edges .

## Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	60	80	100
Maximum Amperage	80	100	130

## Welding Techniques

Clean Weld Area . It Is Not Required To Preheat But If Base Metal Is Highly Carbonized It Should Be Preheated To Approx 350° C . Build Part To Desired Shape By Using As Many Passes As Necessary . Heat To Bright Red Colour . Peen To Relieve Stresses And Remove Slag Between Passes . Use DC Reverse Polarity 35 .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite