

# Felix 230 AC-DC

Premium High Tensile Electrode For Joining All And Any Steels Including Dissimilar Steels .



## Special Features

- \* Special Flux Formulation Produces A Homogeneous , Porosity Free Machinable Weld Deposit .
- \* Tensile Strength Increases In Use Due To Its Work Hardening Qualities Giving The Most Reliable Welds .
- \* Excellent Spray Arc Transfer And Easy Slag Removal .
- \* High Corrosion And Heat Resistance .
- \* Shock And Impact Resistance Equivalent To Manganese Alloy Steels And Other Steels Designed For Impact Applications .

## Typical Properties

Tensile Strength	116000 PSI
Tensile Strength As Work Hardened	175000 PS
Yield Strength	85000 PSI
Elongation	27 %
Hardness	245 Brinell

## International Specifications

AWS/ASME A 5.4 E 312-16  
DIN 8556 : E 29.9 R 23  
ISO 3581: E 29.9 R 32

## Applications

- \* Weld All Tool Steels , Manganese Steels And Speciality Steels In Thick To Thin Designs . Ideal For Joining Tool Steels , Spring Steels , Manganese Alloyed Steels , Rail Steels And Cast Steels .
- \* Weld All Carbon And Alloy Steels - Low-Medium-High In All Positions , Under All Conditions , Including Dissimilar Combinations .

## Recommended Amperage Settings

Diameter(mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	35	60	80
Maximum Amperage	55	75	100	120

## Welding Techniques

Clean Surface . Bevel Heavy Sections To Be Joined . Adjust Amperage Within Recommended Range And Deposit Electrode , Maintaining A Short To Medium Arc Length . Back - Whip Craters And Remove Slag Between Passes Wherever Possible . On High Tool Steels It Is Advisable To Preheat According To Base Metal To Obtain Best Results . DC Reverse Polarity ( Electrode +Ve ) Or AC .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite