

Felix 257 AC-DC

Premium Low Carbon Electrode for Welding Cr- Ni - Mo Stainless Steel .



Special Features

- * Excellent Resistance To Acid and Corrosion .
- * Low Carbon Content Ensures High Resistance To Intercrystalline Corrosion .
- * Good Results On Titanium And Niobium Stabilized Versions Of 316 L Stainless Steels .
- * High Crack Resistance Due to Adequate Ferrite Content .
- * Good Elimination Of Carbide Precipitation Due To Welding .

Typical Properties

Tensile Strength	80000 PSI
Tensile Strength As Work Hardened	97000 PSI
Yield Strength	56000 PSI
Elongation	42%
Impact Energy (150-V/+20 O C)	Min 47 J

Applications

- * 316 And 316 L Stainless Steels .
- * For Welding Tanks , Digestors Evaporators , Pipes , Equipment Made of Cr-Ni-Mo Steels Or Cast Steels .
- * Industries - Chemicals , Food , Textile , Paint , Pharmaceuticals Pulp And Paper .

International Specification

AWS/ASME A 5.4 E 316L-16
DIN 8556: E 19.12.3 LR 26
ISO 3581: E 19.12.3 LR 32

Recommended Amperage Settings

Diameter	5/64 (2.0)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	30	50	65	80
Maximum Amperage	55	75	90	120

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Arc Length Should Be kept As Short As Possible . Avoid Excessive Wide Weaving . Stringer Beads Are Recommended . Redry Electrodes At 200° C For One Hour Before Use . DC Reverse Polarity (Electrode +ve) Or AC .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite