

Felix 266 AC-DC

Premium Low Carbon Electrode for Welding Heat Resistant Ferritic Chrome Steels And Austenitic Cr- Ni Steels .



Special Features

- * Excellent Heat And Crack Resistance .
- * Weld Deposits Are Free Of Porosity .
- * Superior Flux Chemistry Gives Good Arc Transfer And Easy Slag Removal .
- * Excellent Scaling Resistance .
- * Low Carbon Helps Eliminary Carbon Precipitation At High Temperatures .

Typical Properties

| | |
|-----------------------------------|------------|
| Tensile Strength | 78000 PSI |
| Tensile Strength As Work Hardened | 105000 PSI |
| Yield Strength | 73000 PSI |
| Elongation | 32% |
| Impact Energy (150-V/+20 O C) | Min 47 J |

Applications

- * For Welding Of Similar Type Austenitic Stainless Steels , Steels To Stainless Steels , Buffer Layers On Low Carbon / Low Alloy Steels Prior To Build Up .
- * Industries - Refinery , Chemical , Petrochemicals , Textile Etc .

International Specification

AWS/ASME A 5.4 E 309L -16
EN : E23 12 LR 32
ISO 3581: E23 12 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