

Felix 761 AC-DC

Premium Low Hydrogen Hardfacing Electrode With Resistance To Severe Wear And Moderate Impact .



Special Features

- * Basic Hardfacing Offering High Abrasion Resistance With Moderate Impact Resistance .
- * The Deposit Is Not Machinable But Can Be Ground If Necessary .
- * Multi Layers Can Be Applied Without Use Of Buffer Layer .
- * High Crack Resistance .

Typical Properties

Hardness	58-63 HRC
Wear Coefficient	2 %

Applications

- * Typical Application Include Crusher Hammers , Dipper Teeth , Mill Hammers , Drill Bits , Rebound Crushers , Excavators Parts , Mixer Arms , Impellers , Chutes , Rolling Crushers , Conveyor Buckets , Grader Blades , Coal Crusher Segments And Many More Operating In Sand , Clay , Cement And Coal .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	70	90	120	150
Maximum Amperage	90	120	140	180

Welding Techniques

Clean Weld Area . Stringer Beads Or Weaves Can Be Used With Short Arc Lengths . Full Hardness Can Be Achieved With Maximum 3 Layers . Minimal Slag Is Produced And Can Be Overwelded Without Prior Removal .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite