

# Felix 662 (AWS-8018G)

Premium All Position Basic Coated Iron Powder Low Hydrogen Type Electrode For Welding Of High Tensile Fine Grained Steels .



## Special Features

- \* High Strength Electrode With High Crack Resistance Enables It To Take Dynamic Loads At High And Low Enviromental Temperatures .
- \* Iron Powder Electrode With Recovery As High As 110 % .
- \* Low Hydrogen X - Ray Quality Weld Deposits With High Metallurgical Purity .
- \* Quiet Stable Arc With Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

## Typical Properties

Tensile Strength	91000 PSI
Yield Strength	78500 PSI
Elongation	28%
Impact Energy ISO-V	80 J At -60° C

## Applications

- \* Typical Applications Include Bridges , Offshore Constructions , Structures , Ship Building , Buildings , Stadiums , Boilers , Pressure Vessels , Heavy Machinery , Tanks And Fabrication Of Quenched And Tempered Low Alloy High Strength Steels .

## International Specifications

AWS/ASME A5.5 : E8018-G

## Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Length	350	350	350	450
Minimum Amperage	60	90	130	180
Maximum Amperage	85	130	180	230

## Welding Techniques

Clean Weld Area . Keep Electrodes Dry And Re-Dry The Electrodes If Necessary At 300° C For 2 Hour . Stringer Beads Or Weaving Technique Can Be Used . Maintain Short Arc For Best Mechanical Properties . For Best Results DC Reverse Polarity .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite