

Felix 671 (AWS-9018G)

Premium Basic Coated Iron Powder Low Hydrogen Type Electrode
For Welding Of High Strength Steels .



Special Features

- * Balanced Alloying Elements Provide High Tensile Strength With Good Notch Toughness .
- * Good Resistance To Cracking In Conditions Of Impact , Vibration At Service Temperatures Between -60°C To $+450^{\circ}\text{C}$.
- * Low Hydrogen X - Ray Quality Weld Deposits With High Metallurgical Purity .
- * Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

Typical Properties

Tensile Strength	85000 PSI
Yield Strength	96000 PSI
Elongation	22%
Impact Energy ISO-V	60 J At -60°C

Applications

- * Typical Applications Include Offshore Constructions , Heavy Structures , Pressure Vessels , Vehicles , Heavy Machinery , Penstocks , Tanks And Fabrication Of Quenched And Tempered Low Alloy High Strength Steels .

International Specifications

AWS/ASME A5.5: E9018-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