

# Felix 689 (AWS-11018G)

Premium Basic Coated Very Low Hydrogen Electrode For Welding Of High Strength Fine Grained Steels .



## Special Features

- \* Balanced Alloying Of Manganese , Nickel And Molybdenum For Highest Crack Resistance .
- \* Excellent Impact Values At Sub Zero Temperatures .
- \* X - Ray Quality Weld Deposits With High Metallurgical Purity .
- \* Easy Slag Removal , Easy Restrike And Excellent Weld Appearance .

## Typical Properties

Tensile Strength	119000 PSI
Yield Strength	104000 PSI
Elongation	22%
Impact Energy ISO-V	85 J At -50° C

## Applications

- \* Typical Applications Include Crane Booms , Submarines , Shipbuilding , Pressure Vessels , Trailer Frames And Fabrication Of Quenched And Tempered Low Alloy High Strength And Steels .

## International Specifications

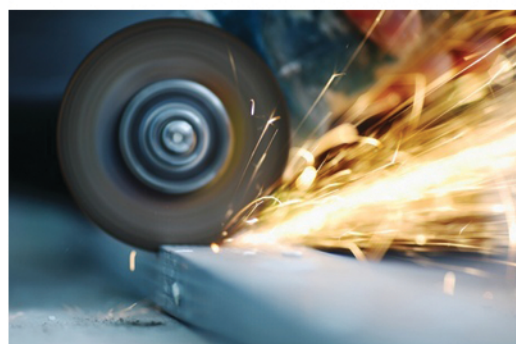
AWS/ASME A5.5: E11018-G

## 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