

# Felix 740 AC-DC

Premium Rutile Based High Hardness Electrode For High Speed Tool Steels .



## Special Features

- \* Tungsten , Vanadium And Molybdenum As Alloying Elements For Edge Retention At Higher Temperatures .
- \* The Deposit Is Not Machinable But Can Be Ground If Necessary .
- \* Good Resistance To Impact And Metal To Metal Wear .
- \* Deposits Are Heat Treatable .

## Typical Properties

Hardness	58 - 62 HRC
Hot Hardness	56 HRC At 600° C
Heat Treated	63 - 65 HRC

## Applications

- \* Typical Application Include Tools For Hot Trimming And Cold Punching , High Speed Steel Dies , Hot Shears , Forging Tools , Tongs For Billets , Mill Cutters , Drawing Mandrels , Mill Cutters Etc .

## International Specifications

AWS/ASME A 5.13 E Fe 6  
DIN 8555 : E4-UM-60-ST

## Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	5/32 (4.0)
Minimum Amperage	45	70	100
Maximum Amperage	85	110	140

## Welding Techniques

Clean Weld Area . Stringer Beads Or Minimal Weaves Can Be Used With Short Arc Lengths . Recommended Use Of Felix 230 As Buffer Layer . Preheat Tool Steels To 400° C But No Preheating Required For Carbon Steels . Use AC Or DC Reverse Polarity .



**FELIX**  
Innovative Metallurgy

A Quality Product From Ferrite