

Felix 311 AC-DC

Premium Multipurpose Electrode For Gauging , Chamferring ,
Cutting & Piercing .



Special Features

- * Blasting Arc Yielding High Speed And Clean Cutting And Gauging .
- * No Compressed Air Or Oxygen Required .
- * Excellent All Position Welding And Restrike Capability .
- * Designed To Operate On All Types Of Welding Machines With Limited Capacity .

Applications

- * Ideal For Gouging , Cutting And Chamfering Of Unalloyed And Low Alloyed Steels , Cr-Ni , Cr-Ni-Mo And Other Alloyed Stainless Steels , Different Grades Of Cast Irons , Cast Steels , Aluminums And Copper For Which The Oxy-Fuel Cutting Methods Are Not Applicable .

International Specifications

Proprietary Product

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	140	200	280
Maximum Amperage	230	310	430

Welding Techniques

Initiate Arc By Holding Electrode At A Low Angle To The Workpiece (10° To 15°) . Push The Electrode As Fast As The Metal Is Removed . Maintain Shorter Arc For Faster And Cleaner Cut . For Piercing Hold Electrode Vertically And Push In And Out . For Cutting Action Use Sawing Action Technique .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite