

Felix Hibond HR AC-DC

Rutile Based High Strength General Purpose Electrode For Welding Of Complicated Structures Of Mild And Carbon Steels .



Special Features

- * Low Spatter and Welding Fumes .
- * Good Electrode Restrike .
- * Slag Is Self Releasing .
- * Smooth Welding Beads Without Undercuts .

Typical Properties

Tensile Strength	68500 PSI
Yield Strength	59000 PSI
Elongation	26%
Impact Energy (1SO-V/+20° C)	Min 47 J

International Specifications

AWS/ASME A E 6013
EN 499 : E 38 2 R 12
EN ISO 2560-A : E 38 2 R 12

Applications

- * Used For The Welding Of Mild Steels , Galvanized And Some Low Alloy Steels , Automobile Bodies , Truck Frames And Bodies , Ship Building And Repair , Farm Machinery , Ornamental Iron , Metal Furniture , Equipment , Building Structures , Farm Implementations , Machinery Guards , Storage Tanks And General Light Fabrication .
- * Industries - Refinery , Chemical , Petrochemicals , Textile Etc .

Recommended Amperage Settings

Diameter(mm)	3/32 (2.5)	1/8 (3.15)	1/8 (3.15)	5/32 (4.0)	5/32 (4.0)	3/16 (5.0)
Length	350	350	450	350	450	450
Minimum Amperage	40	80	80	110	110	160
Maximum Amperage	80	120	120	150	150	240

Welding Techniques

Clean Weld Area . The Material To Be Welded Should Be Free Of Oil , Grease And Dust . Re - Drying Is Not Required . If Necessary : 100° C For 1 Hour . Felix Hibond HR Electrodes May Be Used In Any Position With AC Or DC (Straight Or Reverse Polarity) .



FELIX
Innovative Metallurgy

A Quality Product From Ferrite