

S-FCF

Type : Basic

Conformances

AWS A5.15/ ASME SFA5.15 ESt

JIS Z3252 DFCFe

EN ISO 1071 - E Z 1

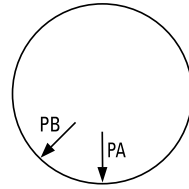
Applications

- Repairing of cast iron

Features

- Machining impossible (As welded)
- Easy to remove slag
- Preheat at 200~350°C (392~662°F)
- Stable arc and good bead appearance

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

| Diameter | Length | P.V.C | |
|-------------|----------|---------------|-------------|
| | | packet | carton |
| mm (in) | mm (in) | 2.5kg(5.5lbs) | 10kg(22lbs) |
| 2.6 (3/32) | 350 (14) | | ✓ |
| 3.2 (1/8) | 350 (14) | | ✓ |
| 4.0 (5/32) | 400 (16) | | ✓ |
| 5.0 (3/16) | 400 (16) | | ✓ |
| 6.0 (15/64) | 450 (18) | | ✓ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Fe |
|------|------|------|-------|-------|------|
| 2.47 | 0.41 | 0.45 | 0.024 | 0.024 | 96.6 |

Typical Mechanical Properties of All-Weld Metal

Hardness (HRB)

450-510

Typical Welding Parameters / Amp.(A)

| Diameter mm (in) | 2.6 (3/32) | 3.2 (1/8) | 4.0 (5/32) | 5.0 (3/16) |
|------------------|------------|-----------|------------|------------|
| Length mm (in) | 300 (12) | 350 (14) | 350 (14) | 400 (16) |
| F | 55-80 | 80-130 | 110-160 | 150-200 |