

S-NFC

Type : Basic

Conformances

AWS A5.15/ ASME SFA5.15 ENiFe-CI

JIS Z3252 DFCNiFe

EN ISO 1071 - E C NiFe-CI 1

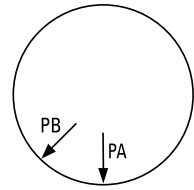
Applications

- Welding of normal grades of cast iron

Features

- Good crack resistance
- Preheat at 100~200°C (212~392°F)
- Easy to remove slag

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	Ni
1.73	0.59	1.34	0.005	0.001	45.7	Bal

Typical Mechanical Properties of All-Weld Metal

Hardness (HRB)
90

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)
Length mm (in)	350 (14)	350 (14)
F	80~130	110~160

SWAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX