

KFN-50

For cast iron

Classifications

EN ISO 1071:2003	: E C NiFe-CI 1
AWS A5.15-90	: ENiFe-CI
KS D 7008	: DFCNiFe
JIS Z 3252	: DFCNiFe

Approvals

CE

Description

- Covering is graphite type for joining of spheroidal graphite cast iron or repairing of cast iron products such as cylinder covers, motor beds, casings and gears
- Good crack resistance and mechanical properties
- Preheat at 150 – 300 °C. The temperature to be applied varies in accordance with kind, shape and size of base metal
- Redry the electrode at 70 - 120 °C for 30 – 60 minutes prior to use

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Fe	Al
0.8	0.36	0.45	0.008	0.002	55.5	0.05	Rem.	0.05

Typical mechanical properties of all-weld metal

Tensile Strength (MPa)	Hardness		
	HV	HB	HS
550	180-210	171-200	26-30

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	550
Amperage	F	60-90	80-120	120-150	140-190