

Covered Electrodes

KFN-50

For cast iron

Classifications

EN ISO 1071:2003	: E C NiFe-Cl 1	KS D 7008	: DFCNiFe
AWS A 5.15-90	: ENiFe-Cl	JIS Z 3252	: DFCNiFe

Description

- Covering is graphite type for joining of spheroidal graphit 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	Cu	Fe	Al
0.80	0.36	0.45	0.008	0.002	55.5	0.05	Rem.	0.05

Typical mechanical properties of all-weld metal

T.S (MPa)	HV	Hardness HB	HS
550	180~210	171~200	26~30

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	550
Amp. (A)	F	60~90	80~120	120~150	140~190

Approvals

CE