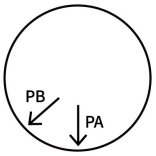
S-FCF

Classification

AWS A5.15/ASME SFA-5.15 Est
JIS Z 3252 DFCFe
EN ISO 1071 E Z 1
KS D7008 DGCFe

Welding Positions





Features

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

Polarity

AC or DC ±

Application Areas

- Repairing of cast iron

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

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(HB)
450~510

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
2.6 (3/32)	300 (12)	55~80	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
3.2 (1/8)	350 (14)	80~130	
4.0 (5/32)	350 (14)	110~160	
5.0 (3/16)	400 (16)	150~200	