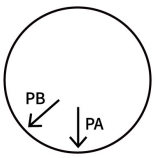
S-NFC

Classification

AWS A5.15/ASME SFA-5.15 ENiFe-CI
JIS Z 3252 DFCNiFe
EN ISO 1071 E C NiFe-CI 1
KS D7008 DGCNiFe

Welding Positions





Features

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

Polarity

AC or DC ±

Application Areas

- Welding of normal grades of cast iron

Redrying Conditions

350°C (662°F) X 1hr

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

C	Si	Mn	P	S	Ni	Fe
1.73	0.59	1.34	0.005	0.001	Bal.	45.7

Typical Mechanical Properties of All-Weld Metal

Hardness(HRB)
90

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	