

KCF-50

AWS (ESt)
JIS (DFCFe)
KS (DFCFe)

FOR CAST IRON

Typical applications

For repairing of various kinds of cast iron products.

Coating

Graphite type.

Characteristics on Usage

- ① Stable arc, easy slag removal and beautiful bead appearance.
- ② Preheat at 200~350°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- ③ Gradual cooling is recommended after welding.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
1.68	0.50	0.35	0.016	0.010

Typical mechanical properties of all-weld-metal

T · S N/mm ² {kgf/mm ² }	El (%)	Hardness (HV)
490 {50}	33	200

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	60~90	90~130	130~180	150~200

Welding positions



Approved by