

FOR CAST IRON

AWS ENiFe-CI  
JIS DFCNiFe  
KS DFCNiFe

# KFN-50

## Typical applications

Joining of spheroidal graphite cast iron. Repairing of cast iron products such as cylinder covers, motor beds, casings and gears.

## Coating

Graphite type.

## Characteristics on Usage

- ① Good crack resistance and mechanical properties.
- ② Preheat at 150~300°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- ③ Redry the electrode at 100~130°C for 30~60 minutes prior to use.

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

C	Si	Mn	Fe	Ni
0.80	0.36	1.45	Rem.	55.5

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Hardness		
	HV	HB	HS
550 {56}	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	350
Amp.	F	60~90	80~120	120~150	140~190

## Welding positions



Approved by