

FOR CAST IRON

JIS
KS

DFCCI
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KL-100

Typical applications

For repairing of all kinds of cast iron product cavity filling.

Coating

Graphite type.

Characteristics on Usage

- ① Preheat at minimum 200°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- ② Gradual cooling is recommended after welding.
- ③ Redry the electrode at 100~150°C for 60 minutes prior to use

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

C	Si	Mn	P	S
3.16	6.27	0.42	0.016	0.011

Typical hardness of all-weld-metal

HV	HRC
280	27.1

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp.	F	110~140	150~190	190~220

Welding positions



Approved by