

# KSN-100

AWS ENi-CI  
JIS DFCNi  
KS DFCNi

FOR CAST IRON

## Typical applications

Repairing and joining of various kinds of cast iron products such as cylinder covers, motor beds, casings and gears.

Repairing of cast iron, alloy cast iron and malleable cast iron.

## Coating

Graphite type.

## Characteristics on Usage

- ① Easily machinable deposited weld metal.
- ② Chip off base metal completely at the repairing part.
- ③ Preheat at 150~200°C. The temperature to be applied varies in accordance with kind, size and shape of base metal.

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

C	Si	Mn	Fe	Ni
0.55	0.40	0.35	0.85	Rem.

## Typical mechanical properties of all-weld-metal

T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Hardness		
	HV	HB	HS
420 {43}	160~190	152~181	24~28

## 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	70~110	110~130	130~150

## Welding positions



Approved by