

S-FCF

COVERED ARC WELDING ELECTRODE
FOR CAST IRON



❖ Specification

<i>AWS A5.15</i>	ESt
<i>JIS Z3252</i>	DFCFe
<i>EN ISO 1071</i>	E Z 1

❖ Applications

S-FCF can be used for welding of cavity filling or repairing of cast iron.

❖ Characteristics on Usage

S-FCF is a graphite coated electrode. It has stable arc and good bead appearance. It is easy to remove slag

❖ Note on Usage

1. The preheat temperatures vary in accordance with shape and size of the base metal.
2. Preheat at 200~350°C (392~662°F), gradual cooling recommended after welding.
3. Keep the weld metal length less than 50mm(2inch) to disperse welding heat .



Mechanical Properties & Chemical Compositions of all-Weld Metal

❖ Typical Chemical Composition of All-weld Metal(wt%)

C	Si	Mn	P	S	Fe
2.47	0.41	0.45	0.024	0.024	96.6

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness (HRB)
-	450~510

❖ Available sizes and Recommended Current

Diameter, mm(in)		2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length, mm(in)		350(14)	350(14)	350(14)	400(16)
Recommended current range (AC or DC+)	Flat (1G-PA)	55~80	80~130	110~160	150~200

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