

S-NFC

COVERED ARC WELDING ELECTRODE
FOR CAST IRON



❖ Specification

<i>AWS A5.15</i>	ENiFe-CI
<i>JIS Z3252</i>	DFCNiFe
<i>EN ISO 1071</i>	E C NiFe-CI 1

❖ Applications

Welding of normal grades of cast iron, such as grey, ductile and malleable irons.
Repairing of cast iron housings, blocks, machinery parts, frames.

❖ Characteristics on Usage

S-NFC is a covered electrode with graphite type coating flux and 55% Ni-fe alloy core rod.

The hardening of the weld metal is less than S-FCF, and Crack resistibility is excellent.

❖ Note on Usage

1. Use currents as low as possible.
2. Keep the weld metal length less than 50mm(2 inch) to disperse welding heat.
3. The preheat temperatures vary in accordance with the size, kind and shape of the base metal. 100~200℃(212~392°F) is appropriate in general.



Mechanical Properties & Chemical Compositions of all-Weld Metal

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

C	Si	Mn	P	S	Fe	Ni
1.73	0.59	1.34	0.005	0.001	45.7	Bal.

❖ Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness (HRB)
—	90

❖ Available sizes and Recommended Current

Diameter, mm(in)		2.6 (3/32)	3.2 (1/8)	4.0 (5/32)
Length, mm(in)		300(12)	350(14)	350(14)
Recommended current range (AC or DC+)	Flat (1G-PA)	50~80	80~130	110~160

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