

Applications

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

Characteristics on Usage

- S-FCF is a graphite type electrode which has a pure iron core rod.
- Stable arc.
- Easy slag removal.
- Beautiful bead appearance.
- Machining is impossible "as welded".

Notes 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 See notes of S-NCl for other cautions.

Welding Position

Current



1G 2F
(PA) (PB)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

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

Approval

Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	400 (16)	400 (16)
F	60~90	90~130	120~160	150~200