

## 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.

## Notes 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°C(212~392°F) is appropriate in general.

## Welding Position



1G 2F  
(PA) (PB)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Fe	Ni
1.17	0.80	1.20	0.010	0.003	54.0	Bal

## Typical Mechanical Properties of All-Weld Metal

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

## Approval

## I Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2 (1/8)	4.0 (5/32)
Length mm(in)	350 (14)	350 (14)
F	80~120	110~150