

Covered Electrodes

KL-100

For cast iron

Classifications

KS D 7008 : DFCCI
JIS Z 3252 : DFCCI

Description

- Covering is graphite type for repairing of all kind of cast iron product cavity filling.
- Preheat at minimum 200°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- Gradual cooling is recommended after welding.
- Redry the electrode at 70~120°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe
3.16	6.27	0.42	0.015	0.006	Rem.

Typical mechanical properties of all-weld metal

Hv	HRC
280	27.1

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	F	110~140	150~190	190~220