



SELECTARC Fonte Fe4/F

Cast Iron Rod
Flux Coated for Hot Welding

Classification

DIN 8573 : G FeC-1
ISO 1071 : R C FeC-1

Characteristics

Flux coated welding rod for oxy - acetylene hot welding of grey cast iron. The deposit shows the same colour and structure as grey cast iron.

Applications

Mainly used to weld defects in Castings with matching colour.

Base materials

ASTM	DIN	NFA
A 48 class 25B - A48 Class 60B	GG-15 to GG-40	FGL 150 to FGL 400

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Cu	Fe
3.30	3.20	0.60	0.50	0.10	Base

All Weld Metal Mechanical Properties (Typical)

Conditions	Hardness (HB) AW
PWHT	186

Instructions

Electrode	ØxL (mm)	4.0 x 450	5.0 x 450
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Prepare the casting defect to be repaired. Preheat the piece using a neutral flame to 550 - 650°C. Keep this temperature during welding. Cool down slowly, preferable in a furnace.