

For cast iron



Type of covering	Brand name	Size (mm)	Equivalent specification	Welding position	Type of current	Typical chemical composition of all-weld-metal(%)								Typical mechanical properties of all-weld-metal			Main use
						C	Si	Mn	P	S	Fe	Ni	Cu	T.S N/ mm ² {kgf/ mm ² }	El. (%)	Hardness (HV)	
Graphite type	DM-150	3.2-5.0	AWS ENiFe-Ci JIS DFCNiFe	F,H-Fil	AC or DC(+)	0.95	0.38	0.66	0.006	0.003	Ba1	54.7	—	490 {50}	—	190	Joining of various types of cast irons. Welding of cast irons to steels and other ferrous and nonferrous materia
	DM-100	3.2-5.0	AWS ENi-Ci JIS DFCNi	F,H-Fil	AC or DC(+)	0.60	0.24	0.32	0.004	0.002	2.42	Ba1	0.01	392 {40}	—	190	Welding of cast irons to themselves or dissimilar metals such as low alloy and carbon steels.