

# GEEFLUX 303 X GEESAW 308L



CLASSIFICATION : JIS Z3324 FSS-B1/YS308 (L)

## CHARACTERISTICS :

Agglomerated basic flux for welding austenitic stainless steel and heat resistance steels. It's behavior as to carbon of the weld metal is strictly neutrall.Excellent weldability such as stable arc and easy slag removal, uniform bead appearance.

## Main constituents

SiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub>	CaF <sub>2</sub>
10%	35%	50%

## APPLICATION :

Welding of austenitic stainless steel grades A181, 304, 304L etc.

## TYPICAL WELD METAL ANALYSIS (%):

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.029	1.72	0.48	0.008	0.024	20.3	9.85	0.08	0.05

## MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Ultimate Tensile Strength MPa	Elongation (%) (L=4D)	Charpy V-notch Impact strength in joules	
560-670	36-45	Temp	<Joules
		-0C	70-95

**SPECIAL INSTRUCTIONS:**

- Dry the flux at 300C -350C for 1 hour before use.
- Avoid using high current to prevent harming of corrosion- resistibility in heat-affected zone. Heat-input in welding should be kept as low as possible.
- Welding in groove should be done in 2 passes to ease slag removal.

**CURRENT CONDITION : AC, DC+****WELDING CONDITION:**

Wire Diameter (mm)	3.15	4.00
Welding Current (A)	300~ 450	400~ 600
Welding Voltage (V)	30~36	30~36
Welding Speed (Cpm)	30~60	30~60

**PACKING SPECIFICATION:**

WIRE - 25.0 Kg, in a spool, FLUX - 25.0 Kg, in a polythene lined bag.