

GEEFLUX 303 X GEESAW 316L - ONGC



CLASSIFICATION : JIS Z3324 FSS-B1/YS316 (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 neutral. Excellent weldability such as stable arc and easy slag removal, uniform bead appearance.

Main constituents :

SiO ₂	Al ₂ O ₃	CaF ₂
10%	35%	50%

APPLICATION:

Welding of austenitic stainless steel grades

A181, 316, 316 etc etc.

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.

TYPICAL WELD METAL ANALYSIS (%) :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.029	1.72	0.48	0.008	0.024	18.6	11.95	2.35	0.05

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

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

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

GEESAW 316L

(AWS/SFA 5.9:ER 316L)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.03 max	1.0-2.50	0.30-0.65	0.03 max	0.03 max	18-20	11-14	2.0-3.0	0.75 max

PACKING SPECIFICATION:

SIZE: 2.0MM, 2.5MM 3.15MM 4.0MM & 5.00MM

WIRE - 25.0 Kg coil wound on a steel former

FLUX - 25.0 Kg, in a polythene lined bag.