

# GEEFLUX 376 X GEESAW 308L



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

## CHARACTERISTICS :

Specialagglomerated basic flux for welding austenitic stainless steel for cryogenic application involving temp of -196C. It's behavior as to carbon of the weld metal is strictly natural. Excellent weld ability 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%

## TYPICAL APPLICATION :

Welding of austenitic stainless steel grades

316L, 304L etc.

## Main constituents :

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	
		Temp	Joules
560-670	36-45	196C	30 - 60

<b>Lateral expansion : at-196C</b>	15 to 30 mills
	0.38 mm to 0.60 mm

**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 : DC+**

**WELDING CONDITION:**

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

**PACKING SPECIFICATION:**

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