

GEEFLUX 505 X EM 14K



SPECIFICATION : AWS/SFA 5.17M : F48AZEM14K/F48AOEM14K

CHARACTERISTICS :

Agglomerated rutile alumina type flux recommended for single and multilayer welding of structural steels. The flux is resistant to porosity and slag detachability are excellent. The consumptions of flux is small and usually is about 1.1kg for 1.0kg of wire.

TYPICAL APPLICATION :

Structural steels

IS : 2062 Grade B or equivalent

H-beams, ships , pipes, general fabrication, Storage tanks, etc

TYPICAL WELD METAL ANALYSIS (%) :

C	Mn	Si	S	P	Cu
0.10 max	01.0 - 1.60	00.25 - 0.60	0.025 max	0.025 max	0.30 max

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE) :

Ultimate Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact strength in joules	
			Temp	Joules
480-600	400-520	22-30	27C	60-100
			0C	50-90

SPECIAL INSTRUCTIONS:

- Dry the flux at 300C -350C for minimum 60mts before use.
- Pay attention to welding voltage. Excess voltage causes. deterioration of joint properties.
- Add fresh flux periodically to prevent weld defects and bead appearance

CURRENT CONDITION: AC/DC(+)**TYPICAL WELD METAL ANALYSIS (%) :**

C	Mn	Si	S	P	Ti	Cu
0.06 - 0.15	0.90-1.40	0.35-0.75	0.025 max	0.025 max	0.03-0.17 max	0.35 max

PACKING SPECIFICATION : 25.0 Kg in a polythene coated gunny bag.