GEEFLUX 505 X EM12K

SPECIFICATION : AWS/SFA 5.17 M:F7AO EM12K

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 or equivalent
- H-beams, ships , pipes, general fabrication, Storage tanks, etc.
- For welding ASTM A573 Grade 70 steel.

GRAIN SIZE: 0.2-2.0mm

TYPICAL WELD METAL ANALYSIS (%) :

C	Mn	Si	S	P
0.10 max	1.0-1.60	0.25-0.60	0.025 max	0.025 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

GRAIN SIZE: 0.2-2.0mm

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(+)

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