GEEFLUX 525W X EB2

Welding flux for submerged –arc welding process

Fluoride –basic type : AWS/SFA 5.23 F8P2 EB2-B2

CHARACTERISTICS :

GEEFLUX 525W X EB2 recommended for welding various grades of creep resistance Cr-Mo steels such as ASTM A335 Gr p11,p12 A 182 F11 Plates B51501,part 2 Grade 620 and Grade 621

Damp flux must be redried at 300-350°C/for 2 to 3 hr

APPLICATIONS:

Welding of various grades of chrome-moly steels.Pressure vessels, pipes, forgings etc.

Main constituents:

$SiO_2 + TiO_2$	CaO+MgO	Al_2O_3+MnO	CaF_2
15%	40%	20%	25%

Basicity according to Boniszewski : Approx. 3.1

All – Weld metal analysis in %

Wire EB2	C = 0.05 – 0.15
	Si = 0.20-0.60
	Mn = 0.6 – 1.20
	S = 0.020 max.
	P = 0.020 max
	Mo=0.40 – 0.65
	Cr = 1.0 – 1.50
	Cu = 0. 30 max

Mechanical properties of the deposited weld metal (With PWHT 6900C/min)

Wire	PWHT 6900C/1hrs	Ultimate Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact strength in joules	
EB2		550 min	480 min	22-28	Temp	Joules
					-20°C	50-100

Packing: 25.0Kg. flux in polythene lined bags