

GEEFLUX 541 X EB2R



Fluoride -basic type

SPECIFICATION : AWS/SFA 5.23 F8P2 EB2R-B2R

Welding flux for submerged -arc welding process

CHARACTERISTICS :

GEEFLUX 541 X EB2R recommended for welding various grades of creep resistance Cr-Mo steels such as ASTM A335 Gr p11, ASTM A387 Gr 11 and equivalents

Flux must be redried at 400-450C/for 2 to 3 hr

TYPICAL APPLICATION :

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

Main constituents

SiO₂ + TiO₂	CaO+MgO	Al₂O₃+MnO	CaF₂
15%	40%	20%	25%

Basicity according to Boniszewski : Approx. 3.1

All - Weld metal analysis typical values in %

Wire EB2R	C = 0.07 - 0.15
	Si = 0.05-0.30
	Mn = 0.50 - 1.0
	S = 0.010 max.
	P = 0.010 max
	Mo= 0.45 - 0.65
	Cr = 1.0 - 1.75
	Cu = 0.30 max
	As = 0.005 max
	Sn = 0.005 max
	Sb = 0.005 max

X factor = max 15 :

Mechanical properties of the deposited weld metal (With PWHT 690C/1 to 6 hrs)
:

Wire	PWHT 690C/1 to 6 hrs	Ultimate Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V- notch Impact strength in joules	
					Temp	Joules
EB2R		5060 min	480 min.	17 min	-18C	54 min

Packing: 25.0Kg. flux in polythene lined bags