

GEEFLUX 541 X ENi2



AWS/SFA 5.23 F8A(P)6 ENi2-Ni2

Fluoride :basic type

Welding flux for submerged -arc welding process

CHARACTERISTICS :

Geeflux-541 is an agglomerated fluoride-basic type flux, preferably used for welding of high-strength fine grain structural steels, as well as cryogenic steels and steels resistant to ageing. Owing to its neutral behaviour as to the pick-up and burn-out of the elements silicon and manganese, it is advisable to use wire electrodes having a higher silicon and manganese content. Geesaw 541 flux is suitable to be employed for welding offshore components. The weld metal produced in combination with corresponding wire electrodes meets high toughness requirements at subzero temperatures. Welds are uniformly shaped, without constrictions and undercuts. The flux is suitable to be used on either DC, positive pole, or AC up to about 1000A.

Damp flux must be redried at 300-350C

TYPICAL APPLICATION :

- Welding of fine grained medium tensile steel such as ASTM A537 Class 2.
- Pressure vessels, pipes, forgings etc.

Main constitu-ents :

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 EA2 (S2-MO)	C = 0.10 max.
	Si = 0.20-0.60
	Mn = 0.70-1.60
	S = 0.025 max
	P = 0.030 max.
	Cu = 0.30 max.
	Ni = 2.0 - 2.80

Mechanical properties of the deposited weld metal (With EA 2 Wire) :

Wire	As welded	Ultimate Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact strength in joules	
					Temp	Joules
ENi2		550-660	480-560	22-28	-50C	50-120

Packing: 25.0Kg. flux in polythene lined bags