

GEEFLUX 541 X GEESAW EF5



CLASSIFICATION: AWS/ASME SFA-5.23 F11A5EF5 - F5

Applications , Properties : Medium - alloy solid electrode designed for submerged - arc welding of high - strength fine grain structural steels in conjunction with highly basis flux - Geeflux 541. Weld metal meets requirements as to mechanical properties in the as-welded and stress - relieved condition. Robake welding flux for 3h at 350 - 400°C before use.

Materials :

Heat treated fine grain structural steels, e.g. A 517 Gr F, N-A-XTRA 63,N-A-XTRA 70,T 1,T 1A,T 1 B and others.

All Weld Metal Analysis % (Typical Values) :

C	Si	Mn	Cr	Ni	Mo	S	P
0.05	0.33	1.5	0.5	2.4	0.4	0.02	0.020

Mechanical Properties of all - weld metal (typical values) :

Yield Strength (mpa)	Tensile Strength (mpa)	Elongation (C = 4d%)
>680	760-830	>16

All weld impact properties :

Heat Treatment	+27°C Min	-40°C
AW	100 Joules	60 Joules

Mechanical properties depend upon cooling conditions. They are influenced by heat input and interpass temperature. Optimal results will be obtained at a heat input of $E \leq 15$ kJ/cm. Interpass temperature should not significantly exceed 150 °C. Steel manufacturer's specifications for welding thinner plates should be observed.

Packing :

Wire	Flux
25 kg spool	25 kg in plastic drum pack