GEEFLUX 541 x EA2

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 300-350°C

TYPICAL APPLICATION :

- Welding of fine grained medium tensile steel such as BS:EN10028-3–All grades to P460NL1.
- Pressure vessels, pipes, forgings etc.
- For penstock fabrication.

GRAIN SIZE: 0.2-2.0mm

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 typical values in %

Wire EA2 (S2-MO)	**C = 0.10 max.**
	Si = 0.20-0.60
	Mn = 1.0-1.4
	S = 0.025 max.
	P = 0.030 max.
	Mo = 0.45-0.65
	Cu = 0.35 max
	Cr = 0.30 max
	V = 0.10 max

Mechanical properties of the deposited weld metal (With EM12K Wire) :

Wire	**As welded**	**Ultimate Tensile Strength MPa**	**0.2% Proof Stress MPa**	**Elongation (%) (L=4D)**	**Charpy V-notch Impact strength in joules**	
EA2 (S2-MO)		550-650	460-560	25 Min	**Temp**	**Joules**
					-20C	50 min

Packing: 25.0Kg. flux in polythene lined bags