

GEEFLUX 541MDH



Fluoride - basic type

Welding flux for submerged-arc welding process

CHARACTERISTICS :

Geeflux 541 MHD is an agglomerated fluoride-basic type flux, preferably used for welding various grades of steel such as ASTM A516 Gr 70 or equivalent, Nace Grade steel/pipes such as ASTM 106 Gr B or equivalent etc. 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. **Geeflux 541 MDH** flux is suitable to be employed for welding processing off-shore components. The weld metal produced in combination with EH 10K MDH electrode meets high toughness requirements at subzero temperature. Welds are uniformly shaped, without constriction and undercuts. The flux is suitable to be used on DC, positive pole, or AC up to about 1000A.

Damp flux must be redried at 300-350°C for 2hrs

Constitu-ents :

Sio2 +TiO2	Cao+MgO	Al2O3+MnO	CaF2
15%	40%	20%	25%

Basicity according to Boniszewski: Approx. 3.0

All - Weld metal analysis typical values in %

**Wire EH 10K
Geeflux 541 MDH**

C = 0.12 max

Si = 0.20 - 0.50

Mn = 1.0 - 1.60

S = 0.012 max

P = 0.015 max

Cu = 0.035 max

Mechanical properties of the deposited weld metal :

Wire	As welded	Ultimate Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact strength in joules	
					Temp	Joules
EH 10K (Geeflux 541 MDH)		510-620	450-550	24-32		
					-30°C	60-150