

GEEFLUX 544



SPECIFICATION : AWS/SFA 5.17 : F7A(P)5

CHARACTERISTICS :

Geeflux-544 is an agglomerated basic flux for submerged arc welding. It is used for single and multi-run welding of all plate thickness.

It works equally well with DC & AC current. The good slag detachability & limited alloying of Si & Mn makes it well suited for multi bias thick section welding. High Welding speed can be achieved producing a finely rippled weld metal, all this in combination with very good impact value.

Damp flux must be redried at 300-350C.

TYPICAL APPLICATION :

IT's one of the most used SAW Flux, not just for structural steels & fine grained steels, but also for weather resistant steels e.g. for bridges.

GRAIN SIZE: 0.2-2.0mm

Main constitu-ents :

$\text{SiO}_2 + \text{TiO}_{2\text{mm}}$	$\text{CaO} + \text{MgO}$	$\text{Al}_2\text{O}_3 + \text{MnO}$	CaF_2
20%	30%	25%	20%

Basicity according to Boniszewski : Approx. 1.7

All - Weld metal analysis typical values in %

Wire EM12K	C = 0.10 max.
	Si = 0.15-0.50
	Mn = 0.90-1.25
	S = 0.025 max.
	P = 0.030 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	
					Temp	Joules
EM12K		500-600	440 min.	22-28	-0°C	50-120

Packing: 25.0Kg. Flux in polythene lined bags