

GEEFLUX 544 x GEESAW EA2



AWS/SFA 5.23 : F8A(P)4EA2-A2

Fluoride -basic type

Welding flux for submerged -arc welding process

CHARACTERISTICS :

Geeflux-544 is an agglomerated fluoride-basic type flux, preferably used for welding of high-strength fine grain structural steels, as well as creep resisting steels. Owing to its neutral behavior 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 544 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.

Flux must be redry at 350-400C/2 hrs before use.

TYPICAL APPLICATION :

- Welding of fine grained medium tensile steel such as steel grade 16Mo3 or equivalent
- Pressure vessels, pipes, forgings, storage tanks, etc.

Main constitu-ents :

SiO₂ + TiO₂	CaO+MgO	Al₂O₃+MnO	CaF₂
15%	40%	20%	25%

Basicity according to Boniszewski : Approx. 3.1

Wire analysis in % :

Wire EA 2	C = 0.05-0.17
	Si = 0.20 max
	Mn = 0.95-1.35
	S = 0.025 max
	P = 0.025 max
	Mo = 0.45-0.65
	Cu = 0.35 max

All - Weld metal analysis with EA2 wire in %:

Wire EA 2	C = 0.12 max
	Si = 0.80 max
	Mn = 1.40 max
	S = 0.03 max
	P = 0.03 max
	Mo = 0.40-0.65
	Cu = 0.35 max

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
EA 2		570-690	520 min	22-28		50-120

PACKING :

GEESAW EA2 : 25kgs

GEEFLUX 544 : 20kgs