

GEEFLUX 581



CLASSIFICATION : AWS SFA F8A2,

CHARACTERISTICS :

Agglomerated alumina-rutile type flux particularly suitable for high speed welding applying the twin-wire process as well as in tandom and multi-wire welding. The flux can be used for welding from both sides in one pass.

If can be used either DC (positive) or AC up to 1000 Amp.

TYPICAL APPLICATION :

- For welding IS:2062 grade or equivalent.
- ST 37-2, ST 44-2
- For fabrication of pipes, Boilers, Pressure Vessels.

Main constitu-ents :

| | | |
|--|--|------------------------|
| SiO₂ + TiO_{2mm} | Al₂O₃+MnO | CaF₂ |
| 26-34% | 45-54% | 8-12% |

Drying of the flux : 350°C/2 hrs.

Recommended Wire: EL8, EL12, S2, EA2.

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

| | | | | |
|-------------|--------------------------------------|------------------------------|------------------------------|---|
| Wire | Ultimate Tensile Strength MPa | 0.2% Proof Stress MPa | Elongation (%) (L=4D) | Charpy V-notch Impact strength in joules |
|-------------|--------------------------------------|------------------------------|------------------------------|---|

| | | | | | |
|----------|---------|-------------|-------|------|--------|
| EL8/EL12 | 500-600 | 425 min. | 22-26 | Temp | Joules |
| | | | | +27 | 50-100 |

Packing: 25.0 Kg Ploythene Lined Bags