

# GEEFLUX 304

## CLASSIFICATION

ISO 14174 -SA AF 2 5644 DC H5 \* (EN760- SA AF 2 DC)

## DESCRIPTION

Specially designed for welding Austenitic and Austenitic-Ferritic stainless steels. This basic-neutral flux will produce outstanding results in the welding of the standard Austenitic and heat-resisting stainless steels, when using the corresponding wire electrodes according to EN ISO 14343 or ASME II C: SFA-5.9. Due to the basic flux characteristics of **Geeflux 304**, most grades of the 300 and 400 stainless steels can be welded using single wire submerged-arc processes. It is also suited for joint- and overlay welding. **Geeflux 304** produces smooth flat weld beads when fillet welding. If appropriate welding parameters are applied a finely ribbed surface along with self-releasing slag is yielded as well as weld beads that are free of slag inclusions. The metallurgical behavior of the flux is neutral (C-neutral, low Si pick-up and low Mn burn-out) without Cr- or other alloy compensation.

## APPLICATION

For surfacing valve with ER 410 and ER 430 grade of stainless steel wires.

## CHEMICAL COMPOSITION

<b>SiO<sub>2</sub> +</b>	<b>Al<sub>2</sub>O<sub>3</sub> +</b>	<b>CaO +</b>	<b>CaF<sub>2</sub></b>
<b>TiO<sub>2</sub></b>	<b>MnO</b>	<b>MgO</b>	
10%	35%	5%	50%

**Basicity according to Boniszewski**  
: ~ 1.9

**Flux Density** : 1.0 Kg/dm<sup>3</sup>(l)

**Grain Size** : 2 - 16

**Current carrying capacity** : Upto 900 A DC using one wire.

**Packaging** : 25 Kg PE-coated

## Storage and Redrying:

Unopened originally packed flux bags can be stored upto one year in dry storage rooms after date of delivery ex-factory.

Redrying conditions specific to the flux: 200 + 50°C effective flux temperature.

## Packing Data:

- Saw Wire: 25 Kg Spool
- Saw Flux: 25 Kg Flux