GWELD
SEAL OF TRUST

GEEFLUX 505(M)

IDENTIFICATION
GEEFLUX 505(M)

CLASSIFICATION
AWS/SFA 5.17 : F7PZ EL8
AWS/SFA 5.17 : ISO 14171-A S1
AWS/SFA 5.17 : F7A2 EM11K
AWS/SFA 5.17 : F7AO/ F7AZ EM12K
AWS/SFA 5.17 : F7AZ EH14
AWS/SFA 5.23 : F7A(P) 2EA2-A2

DESCRIPTION
- Active flux for limited pass welding
- Good general purpose flux, including semi-automatic
- High speed on dirty plate
- Good resistance to porosity on rust and primer
- Good slag removal, good bead shape
- Product also available in a fine grain and grain and coarse formula
- Fin grain formula preferably used on high speed fillet welds applications
- Good on circumferential welds on small diameters with low voltage

CHEMICAL COMPOSITION OF THE WIRE (AS PER AWS/SFA 5.17)

Wire	C	Mn	Si	S	P	Cu
EL8	0.10 max	0.25 - 0.60	0.07 max	0.030 max	0.030 max	0.35 max
EL12	0.04 - 0.14	0.25 - 0.60	0.10 max	0.030 max	0.030 max	0.35 max
EM11K	0.07 - 0.15	1.00 - 1.50	0.65 - 0.85	0.030 max	0.025 max	0.35 max
EM12K	0.05 - 0.15	0.80 - 1.25	0.10 - 0.35	0.030max	0.030 max	0.35 max
EH14	0.10 - 0.20	1.70 - 2.20	0.10 max	0.030max	0.030 max	0.35 max

CHEMICAL COMPOSITION OF THE WELD METAL (AS PER AWS/SFA 5.23)

Wire	C	Mn	Si	S	P	Cu	Mo
EA2-A2	0.12 max	1.40 max	0.80 max	0.030max	0.030 max	0.35 max	0.40 - 0.65

CURRENT CARRYING CAPACITY : AC/DC(+)

BASICITY : 0.7

SOLIDIFICATION SPEED : High

DENSITY : (Kg/dm^3)

PACKING PARAMETERS : 25.0 kg in a polythene lined bags.

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Wire	UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
				Temp.	Joules
EL8	480 min	400 min	22 min	Room Temp.	60 min
				0°C	50 min
EL12	480 min	400 min	22 min	Room Temp.	60 min
				0°C	50 min
EM11K	480 - 600	400 - 500	22 - 30	-0°C	40 min
EM12K	480 - 600	400 - 520	22 - 30	0°C	60 - 100
				0°C	50 - 90
EH14	510 - 620	440 min	22 - 28	-	-
EA2	570 - 680	480 - 560	-	0°C	50 - 120