

GEEFLUX 505

IDENTIFICATION

GEEFLUX 505

CLASSIFICATION

AWS/SFA 5.17M : F7AO EM12K / F7AZ EM12K

AWS/SFA 5.17M : F48AZ EM14K / F48AO EM14K

AWS/SFA 5.17: F7PZ EL8

CHARACTERISTICS

- Agglomerated rutile alumina type flux.
- Recommended for single and multilayer welding of structural steels.
- The flux is resistant to porosity and slag detachability are excellent.
- The consumptions of flux is small and usually is about 1.1kg for 1.0kg of wire.

APPROVALS

| IOT |
|--------------------------|
| GEESAW EL8 X GEEFLUX 505 |

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

| Wire | C | Mn | Si | S | P | Ti | Cu |
|-------|-------------|-------------|-------------|-----------|-----------|-------------|----------|
| EM12K | 0.05 - 0.15 | 0.80 - 1.25 | 0.10 - 0.35 | 0.030 max | 0.030 max | - | 0.35 max |
| EM14K | 0.06 - 0.19 | 0.90 - 1.40 | 0.35 - 0.75 | 0.025 max | 0.025 max | 0.03 - 0.17 | 0.35 max |
| EL8 | 0.10 max | 0.25 - 0.60 | 0.07 max | 0.030 max | 0.030 max | - | 0.35 max |

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

| Wire | UTS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-------|-----------|-----------|------------------|------------------|----------|
| | | | | Temp | Joules |
| EM14K | 480 - 600 | 400 - 520 | 22 - 30 | 27°C | 60 - 100 |
| | | | | 0°C | 50 - 90 |
| | | | | 27°C | 60 - 100 |
| EM12K | 480 - 600 | 400 - 520 | 22 - 30 | 0°C | 50 - 90 |
| | | | | 27°C | 60 min |
| EL8 | 480 min | 400 min | 22 min | 0°C | 50 min |

CHARACTERISTIC CHEMICAL CONSTITUENTS

| SiO ₂ + TiO ₂ | Al ₂ O ₃ + MnO | CaO + Mg | C9F2 |
|-------------------------------------|--------------------------------------|----------|------|
| 30 | 31 | 24 | 15 |

INSTRUCTIONS : Dry the flux at 300°C -350°C for minimum 60 minutes before use.

CURRENT CONDITION : AC / DC (+)

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PACKING PARAMETERS : 25.0 kg in a polythene coated gunny bag.
