GWELD
SEAL OF TRUST

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

CHARACTERSITICS
- 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
EM12K	480 - 600	400 - 520	22 - 30	27°C	60 - 100
				0°C	50 - 90
EL8	480 min	400 min	22 min	27°C	60 min
				0°C	50 min

CHARACTERISTIC CHEMICAL CONSTITUENTS

SiO2 + TiO2	Al2O3 + 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 (+)

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