

GEEFLUX 525W

IDENTIFICATION

GEEFLUX 525W

CLASSIFICATION

AWS/SFA 5.23 :F8P2 EB2-B2

AWS/SFA 5.23 : F8P2 EB2R-B2R

AWS/SFA 5.23 : F9P2 EB3-B3

AWS/SFA 5.23 : F9P2 EB3-B3R

AWS/SFA 5.23 :F8PZ EB8 - B8

AWS/SFA 5.23 : F8PZ EB91-B91

DESCRIPTION

A highly basic, agglomerated flux with a chemical composition and a production method, which guarantees almost neutral metallurgical relations. This flux offers low oxygen and low hydrogen potentials, which permits sub-merged-arc welding of crack-sensitive heat treatable or heat resistant low-alloy steels and high-alloy Martensitic materials.

Geeflux 525W shows good welding characteristics with smooth tie-in and weld bead appearance without slag inclusions or "tiger-tracks", even when high inter-pass temperatures are experienced.

Slag is self-detaching, including in narrow-groove joints.

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

Wire	C	Mn	Si	S	P	Cu	Cr	Mo	Sb	As	Ni	V	Nb (cb)	N	Al	Sn
EB2- B2	0.05 - 0.15	1.2 max	0.8 max	0.03 max	0.03 max	0.35 max	1.00 - 1.50	0.40 - 0.65	-	-	-	-	-	-	-	-
EB2R -B2R	0.05 - 0.15	1.2 max	0.8 max	0.01 max	0.01 max	0.15 max	1.00 - 1.50	0.40 - 0.65	0.005 max	0.005 max	-	-	-	-	-	0.005 max
EB3- B3	0.05 - 0.15	1.2 max	0.8 max	0.03 max	0.03 max	0.35 max	2.00 - 2.50	0.90 - 1.12	-	-	-	-	-	-	-	-
EB3R -B3R	0.05 - 0.15	1.2 max	0.8 max	0.01 max	0.01 max	0.15 max	2.00 - 2.50	0.90 - 1.12	0.005 max	0.005 max	-	-	-	-	-	0.005 max
EB8- B8	0.12 max	1.2 max	0.8 max	0.03 max	0.03 max	0.35 max	8.0 - 10.0	0.80 - 1.20	-	-	-	-	-	-	-	-
EB91- B91	0.08 - 0.13	1.2 max	0.8 max	0.01 max	0.01 max	0.25 max	8.0 - 10.5	0.85 - 1.20	-	-	0.8 max	0.15 - 0.25	0.02 - 0.10	0.02 -0.07	0.04 max	-

MECHANICAL PROPERTIES OF THE DEPOSITED WELD METAL (WITH PWHT 6900C/1 TO 6 HRS)

Wire	UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
				Temp.	Joules
EB2	550 min	480 min	22 - 28	- 20°C	50 - 100
EB2R	560 min	540 min	17 min	-20°C	54 min
EB3	620 min	540 min	17 min	-	-
EB3R	620 min	540 min	17 min	-20°C	54 min
EB8	550 - 690	480 - 580	20 - 28	-	-
EB9	550 min	480 min	20 min	- 20°C	47 min

CHARACTERISTICS CHEMICAL CONSTITUENTS

Al ₂ + MnO	CaO + MgO	SiO ₂ + TiO ₂	CaF ₂
24.9	29.8	18.8	21.5

CURRENT CARRYING CAPACITY : Upto 900A DC using one wire.

*** DIFFUSIBLE HYDROGEN CONTENT H5**

Determined in deposited metal according to the method described in ISO 3690.

TYPE OF CURRENT DC : Redrying conditions 300-350°C.

PACKING PARAMETERS : 25.0 kg in a polythene lined bags.

WIRE SIZES: 1.6 mm, 2.0 mm, 2.4/2.5 mm, 3.15 mm, 4.0 mm.