GEEFLUX 591 X GEESAW EB91

IDENTIFICATION
GEEFLUX 591 X GEESAW EB91

CLASSIFICATION
AWS/SFA 5.23: F9PZ EB91-B91

Description:

- **GEEFLUX 591 X GEESAW EB91** is designed for submerged arc welding. Preheat and interpass temperatures of not less than 200 °C during welding.
- **GEEFLUX 591** is agglomerated highly basic flux designed for welding chrome-moly steels including grade P91. Metallurgical behavior of the flux is neutral. Damp flux must be redried at 400-450°C/for 2 to 3 hr.

Weld Metal Analysis

Wire	C	Mn	Si	S	P	Cu	Cr	Mo	Nb	Ni	V	Nb (cb)	N	Al	Sn
EB91	0.07-0.13	1.25 max	0.30max	0.01 max	0.01 max	0.10 max	8.5-10.5	0.85-1.15	-	1.0 max	0.15-0.25	0.02-0.10	0.03-0.07	0.04 max	-
EB91+ Geeflux 591	0.07-0.13	1.25 max	0.15-0.30	0.010 max	0.010 max	0.10 max	8.0-10.50	0.85-1.20	0.03-0.10	1.0 max	0.15-0.25	-	0.03-0.07	0.04 max	0.005 max

Basicity according to Boniszewski: 2.6 and 2.9

Mn+Ni in the weld metal: 1.20 max

Nitrogen in the weld metal: ≥ (0.5×Aluminum content + 0.03%) minimum.

Hardness of the weld metal as well as HAZ: 195 HV to 320 HV

Diffusible Hydrogen: Max 4 ml/100 grams of the weld metal.

Mechanical properties of the deposited weld metal (PWHT 750°C for 2 hrs min)

Wire	UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value at +20°C	
				Temp	Joules
EB 91	630 min	540 min	17 min	-	27 min

Typical Applications:

- Welding of A 387 grade 91 & equivalent grades of chrome-moly steels.
- For welding of P91 alloyed steel.

Packing: 25.0 Kg. flux in polythene lined bags.