GEESAW EM4 X GEEFLUX 550

AWS/SFA 5.23: F11(A)4 EM4-M4

DESCRIPTION:

Geeflux 550 is an agglomerated basic flux for submerged arc welding. It is used for single and multi-run welding of all plate thickness. It works equally well with DC & AC current. The good slag detachability & limited alloying of Si & Mn makes it well suited for multi pass thick section welding. High Welding speed can be achieved producing a finely rippled weld metal, all this in combination with very good impact value.

Damp flux must be redried at 350degree centigrade, for 2 hours minimum.

Application:

IT's one of the most used SAW Flux, not just for fine grained steels, but for welding Q & T steels such ASTM A 517 Gr B, Gr F etc, fabrication of penstocks in hydropower projects, etc.

GRAIN SIZE: 0.2-2.0 mm

Main constituents:

SiO2 + TiO2	CaO+MgO	Al2O3+MnO	CaF2
15%	40%	20%	25%

Basicity according to Boniszewski: Approx. 3.1

Weld metal Composition:

C	Mn	Si	S	P	Cu	Ni	Mo	Cr	Ti+V+Zr
0.10max	1.30-2.25	0.80 max	0.020 max	0.020 Max	0.30 Max	2.0-2.80	0.30-0.80	0.80 max	0.03 max

Mechanical properties of Weld metal:

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Strength	
760 - 896	676 min	15 min	Temp.	Joules
			- 40°C	47 Min

Basicity as boniszewaski = 3.1

Packing Specification

Plastic drum :20 KG Flux

WIRE: EM4

C	Mn	Si	S	P
0.10 max	1.40-1.80	0.20-0.60	0.015 max	0.010 max
Mo	**Cu**	**V**	**Ti**	**Zr**
0.30-0.65	0.25 max	0.03 max	0.10 max	0.10 max
Cr	**Ni**	**Al**		
0.60 max	2.0-2.80	0.10 max		