



Submerged Arc Welding Flux



GJ-101Q

Fluoride Basic Flux

- GB/T 5293-2018
S49A4UFB-SU34 S55A4UFB-SU4M1
- AWS A5.17M F7A4-EH14
AWS A5.23M F8A4-EA3
- NB/T47018-2011

Product description

Basic Information

- BASICITY: 2.4
- GRAIN SIZE: 10-40 mesh, 12-60 mesh
- DENSITY: 1.3g/cm³
- PACKAGING: 25 kg plastic valve bags, 500/1000 kg large bags

Application

- Fluorine-alkaline type sintered flux has excellent welding process performance, with stable arc, easy slag removal, and beautiful weld formation.
- Its prominent feature is that it can be matched with submerged arc welding wires for bridge steel and used in the bridge industry.
- This flux is a special flux for welding bridge steels. When used with appropriate welding wires, it can weld various low-alloy bridge steels and steels for pressure vessels
- It offers excellent low temperature impact toughness with a variety of wires. With EH14 wire it is recommended for shipbuilding, bridge fabrication, and wind tower applications.

Main constituents

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
15-20	35-45	25-30	20-25



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Wire electrodes used	Yield strength ≥MPa	Tensile strength ≥MPa	Elongation 8%≥%	Impact values ≥J (CVN)		
				+20℃	-20℃	-40℃
H08Mn2E	460	560	28			174
EH14	435	550	29			140
H08Mn2R	470	580	32			117

NOTE:

- Before welding, the flux must be baked at a temperature of approximately 300-350℃ (572-662℉) for 2 hours.
- Before welding, it is essential to remove impurities such as rust, scale, and primer from the surface of the base metal to obtain high-quality welded deposited metal.
- In the case of multi-layer welding, the backing weld of groove welding requires a small current and welding speed.
- Add new flux regularly to prevent flux defects and poor weld bead surface formation when reusing flux.

