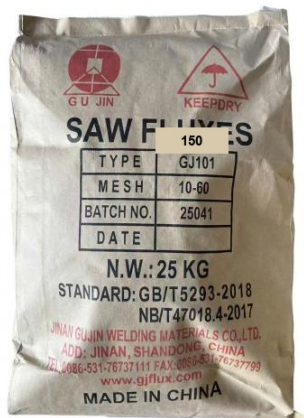




GJ-150

No manganese, medium silicon, medium fluorine fused flux

GB/T 5293-2018

Product description

Basic Information

BASICITY:	1.5 (basic)
GRAIN SIZE:	10-60 mesh
DENSITY:	1.3 g/cm ³
PACKAGING:	25 kg plastic valve bags, 500/1000 kg large bags

Application

- > A no-manganese, medium silicon, medium fluorine fused flux with basic characteristics, primarily used for surfacing and special alloy welding applications.
- > When paired with 2Cr13 or 3Cr2W8 wires, suitable for surfacing rolls and other wear-resistant surfaces. The flux does not add manganese to the weld metal, preserving the target alloy composition.
- > Can also be used for welding copper and copper alloys when paired with copper-based filler wires.
- > Suitable for hardfacing, repair welding, and special alloy cladding applications where precise chemistry control is required.

Main constituents

SiO ₂	Al ₂ O ₃	CaO	MgO	CaF ₂	FeO	S	P
21-23	28-32	3-7	9-13	25-33	≤1.0	≤0.08	≤0.08

Mechanical Properties of Deposited Metal

Application	Wire Type	Surface Hardness	Dilution	Note
Roll surfacing	2Cr13/3Cr2W8	HRC 45-55	≤15%	Multi-layer
Copper welding	Cu-based	—	—	DC+

Note:

Fused flux with low moisture absorption. Dry at 250C for 1-2 hours before use for critical applications.

Wire cleaning: Keep wire and base metal surface clean, free of oil, rust, and moisture.

For surfacing applications: Control dilution by adjusting current, voltage, and travel speed. Multi-layer surfacing recommended for achieving target hardness.

Parameter selection: Conduct process qualification for each specific application. Preheat and interpass temperature control may be required for hardfacing applications.