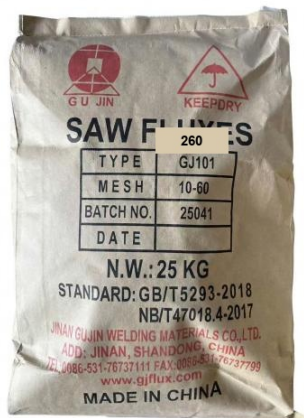




GJ-260

Low manganese, high silicon, medium fluorine fused flux

GB/T 5293-2018

NB/T 47018.4-2017

Product description

Basic Information

BASICITY:	1.0 (neutral)
GRAIN SIZE:	10-60 mesh
DENSITY:	1.2 g/cm ³
PACKAGING:	25 kg plastic valve bags, 500/1000 kg large bags

Application

- > A neutral fused flux with medium fluorine content, suitable for submerged arc welding and electroslag welding of low alloy steels.
- > When paired with H08MnMoA, H08Mn2MoA, and H08Mn2MoVA wires, suitable for welding 15MnV, 14MnMoV, 18MnMoNb and other low alloy high strength steels.
- > Can also be used for welding stainless steels when paired with corresponding stainless wires. The weld metal has good mechanical properties and low temperature impact toughness.
- > Suitable for pressure vessels, heavy machinery, and structural steel fabrication requiring good toughness.

Main constituents

SiO ₂	Al ₂ O ₃	MnO	CaO	MgO	CaF ₂	S	P
29-34	19-24	2-4	4-7	15-18	20-25	≤0.07	≤0.07

Mechanical Properties of Deposited Metal

Wire	Yield ≥MPa	Tensile MPa	Elongation ≥%	Impact 0C ≥J
H08MnMoA	330	410-550	22	27

Note:

Fused flux with low moisture absorption. If stored in humid conditions, dry at 250C for 1-2 hours before use.

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

Groove cleaning: Clean workpiece groove and 20mm range on both sides thoroughly.

Parameter selection: Select appropriate welding parameters according to steel grade, plate thickness, and groove form. Conduct process qualification before production welding.