



GJ-301

Calcium-silicon type sintered flux

- GB/T 5293-2018 / NB/T 47018.4-2017
- AWS A5.17 F6A2-EL12 F7A2-EM12K

Product description

Basic Information

- BASICITY: 1.0
- GRAIN SIZE: 10-40 mesh, 12-60 mesh
- DENSITY: 1.2g/cm³
- PACKAGING: 25 kg plastic valve bags, 500/1000 kg large bags

Application

- Can be used for single-pass, multi-layer, and double-sided single-pass welding.
- Suitable for welding of low carbon steel and low alloy steel structures when used with H08A, H08MnA, and EM12K wires.
- Excellent slag detachability, producing a smooth weld bead with a beautiful appearance and natural metallic luster.
- Applicable to steel structures: heavy steel, H-type steel, boilers, and pressure vessels.
- Highly resistant to rust, oil, and moisture on the base metal, minimizing the risk of porosity.
- Recommended applicable industries: General structural steel fabrication, shipbuilding, and heavy machinery.

Main constituents

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂
25-35	20-30	20-30	5-15



Submerged Arc Welding Flux

Wire electrodesused	Yieldstrength ≥MPa	Tensilestrength ≥MPa	Elongation8%≥%	Impactvalues≥J (CVN)		
				+20℃	0℃	-40℃
EM12K	370	470	32		64	
EL8	380	485	32		106	

NOTE:

- Since it is a sintered flux, it is prone to absorbing moisture. It must be dried at a temperature of 300℃ for 2 hours before use to prevent pores from forming in the weld. Unused flux should be put back into the oven for heat preservation.
- Wire cleaning: The surface of the welding wire should be kept clean, free of oil, rust, and moisture.
- Groove cleaning: The workpiece groove and the 20mm range on both sides need to be cleaned thoroughly to remove impurities such as water, oil, rust, and paint.
- Parameter selection: Appropriate welding current, voltage, and speed should be selected according to the steel plate thickness, groove form, welding position, etc. It is recommended to refer to the parameter table provided by the flux manufacturer and conduct process evaluation.

