



GJ-330

Medium manganese, high silicon, low fluorine fused flux

GB/T 5293-2018 F5A4-H10Mn2

NB/T 47018.4-2017

Product description

Basic Information

BASICITY:	0.6 (acid)
GRAIN SIZE:	10-60 mesh
DENSITY:	1.1 g/cm ³
PACKAGING:	25 kg plastic valve bags, 500/1000 kg large bags

Application

- > A medium manganese, high silicon, low fluorine fused flux with acid characteristics, suitable for high current submerged arc welding.
- > When paired with H10Mn2 (EH14) wire, suitable for welding important low carbon steel and low alloy steel structures such as boilers, pressure vessels, and shipbuilding.
- > The flux causes slight increase of manganese and silicon in the weld metal, ensuring high toughness properties. Suitable for welding plates of unlimited thickness with multi-pass technique.
- > Can be used with both AC and DC power sources at high current up to 900A per wire. Excellent for high-speed automatic welding applications.

Main constituents

SiO ₂	Al ₂ O ₃	MnO	CaO	MgO	CaF ₂	FeO	S	P
44-48	≤4	22-26	≤3	16-20	3-6	≤1.5	≤0.08	≤0.08

Mechanical Properties of Deposited Metal

Wire	Yield ≥MPa	Tensile MPa	Elongation ≥%	Impact ≥J
H10Mn2 (EH14)	390	490-670	18	27

Note:

Fused flux with low moisture absorption. Generally does not require drying. If damp, dry at 250C for 1-2 hours.

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: Suitable for high current welding. Select parameters according to plate thickness and joint design. Multi-pass welding recommended for thick sections.