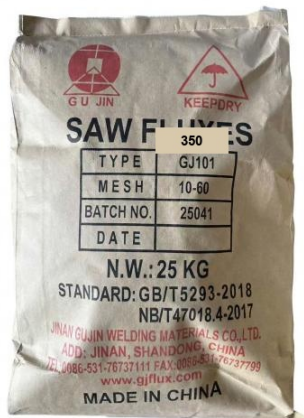




GJ-350

Medium manganese, medium silicon, medium fluorine fused flux

GB/T 5293-2018

NB/T 47018.4-2017

Product description

Basic Information

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

Application

- > A medium manganese, medium silicon, medium fluorine fused flux with neutral-basic characteristics, suitable for submerged arc welding of low alloy steels.
- > When paired with H08MnMoA, H08Mn2MoA wires, suitable for welding low alloy heat-resistant steels and high strength steels such as 15CrMo, 12Cr1MoV.
- > The weld metal has good impact toughness at low temperatures and excellent crack resistance in restrained joints.
- > Suitable for pressure vessels, boiler components, and heavy structural welding requiring good low temperature toughness.

Main constituents

SiO ₂	Al ₂ O ₃	MnO	CaO	CaF ₂	S	P
30-35	13-18	14-19	10-18	14-20	≤0.06	≤0.07

Mechanical Properties of Deposited Metal

Wire	Yield ≥MPa	Tensile ≥MPa	Elongation ≥%	Impact -20C ≥J
H08MnMoA	400	490	22	34

Note:

Fused flux with low moisture absorption. Dry at 250C for 1-2 hours if damp 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 to remove impurities.

Parameter selection: Select appropriate current, voltage, and travel speed according to steel grade and thickness. Preheat may be required for thick sections and high restraint joints.