



GJ-401

Silicon-manganese type agglomerated flux (acid)

GB/T 5293-2018 F5A0-H08A

NB/T 47018.4-2017

Product description

Basic Information

BASICITY:	0.8 (acid)
GRAIN SIZE:	10-60 mesh (2.0-0.28mm)
DENSITY:	1.1 g/cm ³
PACKAGING:	25 kg plastic valve bags, 500/1000 kg large bags

Application

- > A silicon-manganese type acid sintered flux, gray-brown to black round granules. Good welding process performance with high resistance to porosity.
- > When paired with H08A wire, suitable for welding low carbon steel and certain low alloy steel structures. The flux adds silicon and manganese to the weld metal, ensuring good deoxidation.
- > Suitable for welding locomotive vehicles, mining machinery, general steel structures, and non-critical pressure components. Can be used with both AC and DC power sources.
- > Excellent for high-speed automatic welding and semi-automatic welding. Good slag detachability and smooth weld bead appearance.

Main constituents

SiO ₂ +TiO ₂	MnO+Al ₂ O ₃	CaO+MgO	CaF ₂	S	P
~45	~30	~10	~5	≤0.06	≤0.08

Mechanical Properties of Deposited Metal

Wire	Yield ≥MPa	Tensile ≥MPa	Elongation ≥%	Impact 0C ≥J
H08A (EL8)	330	410-550	22	27

Note:

Acid sintered flux with moderate moisture absorption. Dry at 250-300C for 1-2 hours before use to prevent porosity.

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 water, oil, rust, and paint.

Parameter selection: Suitable for general structural welding. Select parameters according to plate thickness and joint design. Not recommended for critical pressure vessel applications requiring high toughness.