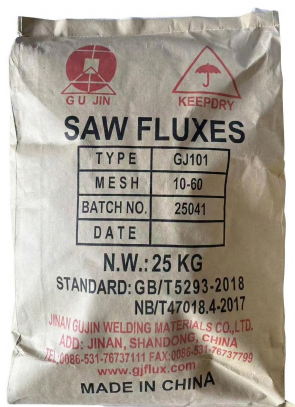




## Submerged Arc Welding Flux

**GJ-431****Fused Flux**

➤ GB/T5293-2018 (S 49A 2-SU34)

**Product description****Basic Information**

- BASICITY: 1.1
- GRAIN SIZE: 10-40 mesh
- PACKAGING: 25 kg plastic valve bags, 500/1000 kg large bags

**Application**

- When applied with welding wire such as H08A, H08MnA, H10Mn2 or H10MnSi, HJ431 can weld low carbon steel and some low alloy steel like 16Mn and 15MnV, as well as ships, boilers and low pressure vessels. And it can be used for electroslag welding and copper welding.
- Stable arc: It can maintain a very stable arc whether under
- DC or AC power supply, especially suitable for AC power. ◦ Excellent slag detachability: After the weld cools, the slag
- Will automatically curl up and can be removed with a light tap, which greatly improves the slag cleaning efficiency.
- Beautiful weld formation: The weld surface is smooth and flat with fine and uniform lines.

**Main constituents**

| SiO <sub>2</sub> +TiO <sub>2</sub> | CaO+MgO | Al <sub>2</sub> O <sub>3</sub> +MnO <sub>2</sub> | CaF <sub>2</sub> |
|------------------------------------|---------|--------------------------------------------------|------------------|
| 40-45                              | 7-14    | 35-42                                            | 3-17             |

**JINAN GUJIN WEDLING MATERIALS**

Laiwu District, Jinan City, Shandong Province.



Submerged Arc Welding Flux

| Wire electrodesused | Yieldstrength<br>≥MPa | Tensilestrength<br>≥MPa | Elongation8%≥% | Impactvalues≥J<br>(CVN) |       |       |
|---------------------|-----------------------|-------------------------|----------------|-------------------------|-------|-------|
|                     |                       |                         |                | +20°C                   | -20°C | -40°C |
| EL8                 | ≥330                  | ≥415                    | ≥22            | 100                     | 40    |       |
| EM12K               | ≥390                  | ≥415                    | ≥22            | 110                     | 50    |       |
| SU34                | 550                   | 450                     | 30             |                         | 100   |       |

NOTE:

- Drying temperature: 300°C - 350°C.
- Holding time: 2 hours.
- Storage: After drying, it should be placed in an incubator at
- 100°C - 150°C and taken as needed.
- Exposure time: The exposure time in the air should not
- exceed 4 hours; otherwise, it needs to be dried again.
- Strictly prohibited: Use flux that is damp, caked, or mixed
- with foreign objects.

