



GJ-501

Aluminum-titanium type agglomerated flux (acid)

GB/T 5293-2018 F6A0-H08A / F6A2-H08MnA

NB/T 47018.4-2017

AWS A5.17 F6A0-EL12

Product description

Basic Information

BASICITY:	0.5-0.8 (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

- > An aluminum-titanium type acid sintered flux, dark brown round granules. The most economical sintered flux for general carbon steel welding.
- > When paired with H08A, H08MnA wires, suitable for welding low carbon steel and low alloy steel structures. The flux has good welding process performance and high resistance to rust and oil on base metal.
- > Suitable for welding general structural steel, shipbuilding hulls, bridges, H-type steel, steel pipe, and LPG cylinders. Can be used with both AC and DC power sources.
- > Excellent for high-speed automatic welding with stable arc and easy slag removal. Produces smooth weld bead with good appearance.

Main constituents

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaF ₂	S	P
25-35	50-60	3-10	≤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
H08MnA (EM12)	330	415-550	22	34

Note:

Acid sintered flux with moderate moisture absorption. Dry at 250-300C for 1-2 hours before use. Unused flux should be stored in dry conditions.

Wire cleaning: Keep wire surface clean, free of oil, rust, and moisture. The flux has good tolerance to minor rust and oil on base metal.

Groove cleaning: Clean workpiece groove and 20mm range on both sides to remove heavy rust, oil, and paint.

Parameter selection: Suitable for general structural welding. Select parameters according to plate thickness and joint design. For high-speed welding, adjust voltage and travel speed for optimal bead formation.