



GJ-502

Alumina-calcium type agglomerated 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:	1.1 g/cm ³
PACKAGING:	25 kg plastic valve bags, 500/1000 kg large bags

Application

- > An alumina-calcium type sintered flux with neutral-basic characteristics, providing a good balance between welding process performance and weld metal toughness.
- > When paired with H08A, H08MnA, H10Mn2 wires, suitable for welding low carbon steel and low alloy steel structures requiring moderate impact toughness.
- > The flux has good slag detachability, stable arc, and produces weld beads with smooth appearance and natural metallic luster. Suitable for both single-pass and multi-pass welding.
- > Suitable for welding pressure vessels, boiler components, structural steel, and general fabrication. Can be used with both AC and DC power sources.

Main constituents

SiO ₂ +TiO ₂	CaO+MgO	Al ₂ O ₃ +MnO	CaF ₂	S	P
15-20	25-30	25-30	15-20	≤0.03	≤0.03

Mechanical Properties of Deposited Metal

Wire	Yield ≥MPa	Tensile ≥MPa	Elongation ≥%	Impact -20C ≥J
H08MnA (EM12K)	360	480-600	24	34

Note:

Sintered flux with moderate moisture absorption. Dry at 300C for 2 hours before use to prevent weld 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: Select appropriate current, voltage, and travel speed according to plate thickness and groove form. Conduct process evaluation before production welding.