

STRONG FLUX - GP

FLUX FOR SUBMERGED ARC WELDING

CLASSIFICATION: AWS SFA 5.17 F7AZ-EL8, F7A2-EM12K



CHARACTERISTICS

STRONG FLUX GP is an agglomerated Alumina-Rutile type flux mainly for welding in fillet and square butt joints. It is suitable for single; two and multi pass welding of heavy thickness plate. This flux being active in nature is suitable for use with EL8 and EM12K submerged arc wires. It gives X-ray quality welds with superior mechanical properties.

APPLICATIONS

General structural steels, Girder, Pipes steels, Penstock shells, PEB's, Earthmoving equipment, High mast poles, Offshore platforms and Boilers involving medium steels.

CURRENT CARRYING CAPACITY

This flux exhibits stable operating characteristics up-to 800 amps. Flux is suitable for use with both AC and DC for single wire, Twin wire and tandem wire (AC/DC).

FLUX TYPE - Alumina - Rutile

BASICITY INDEX - 0.90 (Boniszewski)

GRAIN SIZE - 15-35 MESHES

COMPOSITION OF THE FLUX (%)

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P
20.0-25.0	5.0-10.0	55.0-60.0	5.0-10.0	0.035 MAX	0.040 MAX

ALL WELD MECHANICAL PROPERTIES

SAW WIRE	C	Mn	Si	S	P	Cu	Y.S.	U.T.S.	ELONGATION (L=4D)	CHARPY V NOTCH IMPACT	
	%						MPa	MPa	%	0°C	-18°C
EL8	0.05	0.70	0.30	0.025	0.025	0.30	400	490	>30	>30	-
EM12K	0.07	1.00	0.40	0.025	0.025	0.30	420	520	>28	>50	>30

WELDING PARAMETERS - Current up-to 800 amps, Voltage: 24-34 V, Speed: Up-to 0.80 mts/min.

PACKAGING SPECIFICATION - In 25 kg Paper / PP Bag with Plastic liner.

RE-DRYING CONDITION - Recommended at 300°- 350°C for 2 hours.