



AUTOMELT H45

AGGLOMERATED HARDFACING SUBMERGED ARC WELDING FLUX

CLASSIFICATIONS

EN 760 SA CS 3 97 C Cr Mo DC DIN 3252 B CS 3 97 DC

BASICITY: 0.7

WALL NEUTRALITY NO.: 45

CURRENT CONDITIONS: DC(+) 800A max.

GRAIN SIZE,MM
0.25- 2.00

REDRYING CONDITIONS
250°C for 1 hour

MAIN CONSTITUENTS (APPROX.), %
SiO₂ + TiO₂ : 50 CaO + MgO : 25
Al₂O₃+ MnO : 20 CaF₂: 5

CHARACTERISTICS

Calcium- Silicate type, alloying flux. Smooth shiny beads. Easy slag removal. Crack resistant weld.

TYPICAL APPLICATIONS

For surfacing of tractor rollers, track links, crane track wheels etc. Properties are achieved with wire/flux combination, do not change the wire.

MECHANICAL PROPERTIES- ALL-WELD		
With wire Automelt Grade	Condition	Hardness, BHN (2 layer weld pad)
EL8	AW	420-460

AW : As-welded.

WELD METAL CHEMISTRY, wt%					
With wire Automelt	C	Mn	Si	Cr	Mo
EL8	0.20	1.20	0.80	4.35	0.70

PACKING DATA	
	Net. Wt.,kgs
Poly-lined paper bags (Standard)	25
Steel drums (On request)	100