



**SAW Fluxes**

**AUTOMELT A55 (AUTOMELT Gr II)**



**GENERAL DESCRIPTION:**

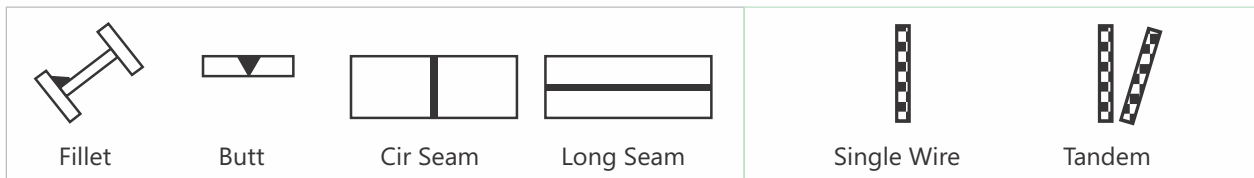
- Agglomerated Flux
- Aluminate- Rutile Type Flux
- Acidic Flux having Basicity Index of 0.6
- Active Flux with moderate Si and Mn pick-up
- For Single and Multi-pass Butt and fillet welding (With EM12K Wire restrict to 15 mm thickness for multi-pass)
- For Carbon Steels
- Suitable for Single Wire & Tandem System
- Suitable for Welding Speeds of 0.35-0.60 m/min
- Grain Size – 0.25-2.00 mm
- Type of Current – DCEP / AC 800A
- Wall Neutrality Number with EL8 Wire is 56

**CLASSIFICATION :**

With Wire	AWS 5.17/5.23	Single / Multi-pass
<b>AUTOMELT EL8 (AUTOMELT Gr.A)</b>	F7AZ/PZ-EL8	Multi-pass
<b>AUTOMELT EL12</b>	F7AZ/PZ-EL12	Multi-pass
<b>AUTOMELT EM12K</b>	F7A0/P0-EM12K	Limited Multi-pass
<b>AUTOMELT EH11K</b>	F7AZ-EH11K	Single Pass

**TYPICAL APPLICATIONS :**

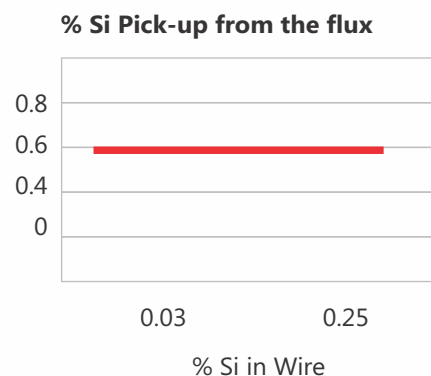
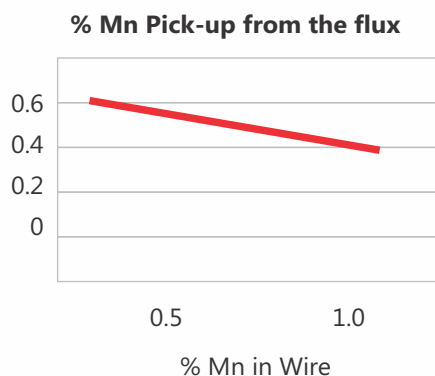
- General Structural Welding
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Cylinders and vessels



**APPROVALS:**

RDSO, ABS, BV, DNV, IRS, LRA, MND, IBR

**ACTIVITY OF THE FLUX:**



(continue...)



SAW Fluxes

**AUTOMELT A55 (AUTOMELT Gr II)**



**CHEMICAL COMPOSITION OF FLUX:**

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>
30	10	45	15

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:**

With wire	C	Mn	Si
<b>Automelt EL8 (Automelt Gr.A)</b>	0.06	1.10	0.65
<b>Automelt EL12</b>	0.08	1.20	0.65
<b>Automelt EM12K</b>	0.07	1.40	0.80
<b>Automelt EH11K</b>	0.07	1.80	1.10

**MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:**

With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact	
					0°C	-20°C
<b>Automelt EL8 (Automelt Gr.A)</b>	AW	530	440	25	50	--
<b>Automelt EL8</b>	PW	500	420	27	60	--
<b>Automelt EL12</b>	AW	540	450	26	50	--
<b>Automelt EL12</b>	PW	510	430	28	60	--
<b>Automelt EM12K</b>	AW	540	450	28	--	40
<b>Automelt EM12K</b>	PW	510	430	30	--	50

AW – As Welded; PW – After Post weld heat treatment of 620°C for 1 hour

The chemistry and mechanical properties will depend on actual wire chemistry and arc voltage