



AUTOMELT B22 PLUS

SAW Flux

GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- Basic Flux having Basicity Index of 1.8
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding
- For Carbon & Low Alloy Steels
- Suitable for Single Wire and Multiple wire tandem System
- Suitable for Welding Speeds of 0.40-0.60 m/min
- Grain Size - 0.25-1.60 mm
- Type of Current – DCEP / AC
- Wall Neutrality Number with EH12K Wire is 23

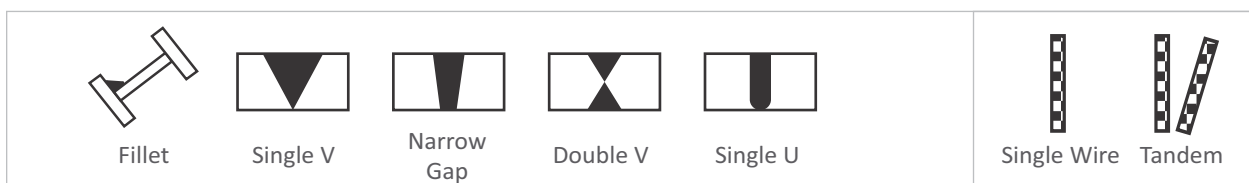
APPROVALS: CE

CLASSIFICATION :

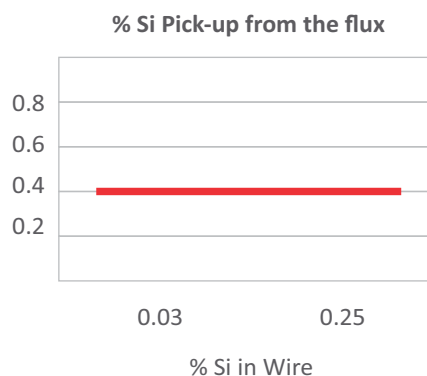
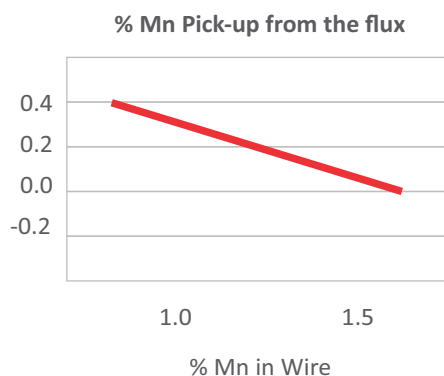
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EM12K	F7A5/F6P5-EM12K	Multi-pass
AUTOMELT EH10K	F7A4/P4-EH10K	Multi-pass
AUTOMELT EH12K	F7A4/P4-EH12K	Multi-pass

TYPICAL APPLICATIONS :

- Wind Mill Fabrication
- Boiler and Pressure Vessel Fabrication



ACTIVITY OF THE FLUX:



(continue...)



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CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
30	20	25	20

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

With wire	C	Mn	Si
Automelt EM12K	0.06	1.40	0.30
Automelt EH10K	0.06	1.50	0.30
Automelt EH12K	0.07	1.50	0.30

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact	
					-40°C	-46°C
Automelt EM12K	AW	510	430	27	60	40
Automelt EM12K	PW	480	400	27	70	50
Automelt EH10K	AW	520	440	28	40	-
Automelt EH10K	PW	510	430	28	50	-
Automelt EH12K	AW	540	450	28	40	-
Automelt EH12K	PW	520	440	28	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

Available in Standard packing of 30 Kg Bag