



SAW Fluxes
AUTOMELT B22 PLUS



GENERAL DESCRIPTION:

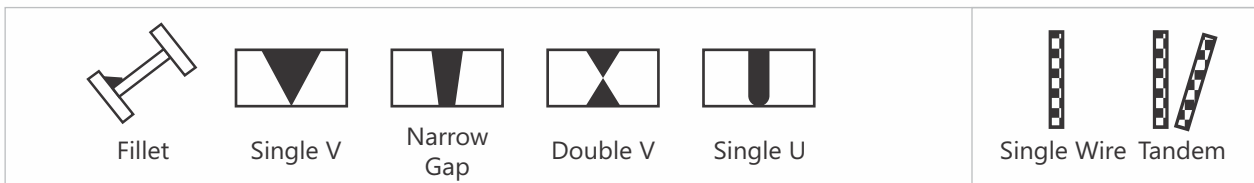
- Agglomerated Flux
- Fluoride-Basic Type Flux
- Basic Flux having Basicity Index of 1.8
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding
- For Carbon & Low Alloy Steels
- Suitable for Single Wire and Multiple wire tandem System
- Suitable for Welding Speeds of 0.40-0.60 m/min
- Grain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

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 :

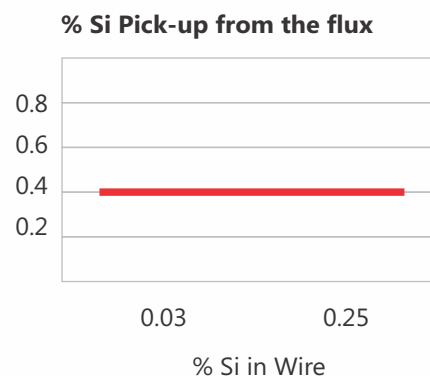
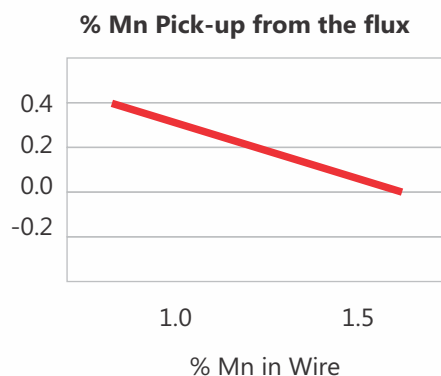
- Wind Mill Fabrication
- Boiler and Pressure Vessel Fabrication



APPROVALS:

CE

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