



AUTOMELT B31 (AUTOMELT Gr IV)

SAW Flux

GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- Basic Flux having Basicity Index of 1.6
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding
- For Carbon Manganese Steels
- Suitable for Single Wire System
- Suitable for Welding Speeds of 0.40 – 0.60 m/min
- Grain Size – 0.25-2.00 mm
- Type of Current – DCEP
- Wall Neutrality Number with EH14 Wire is 7

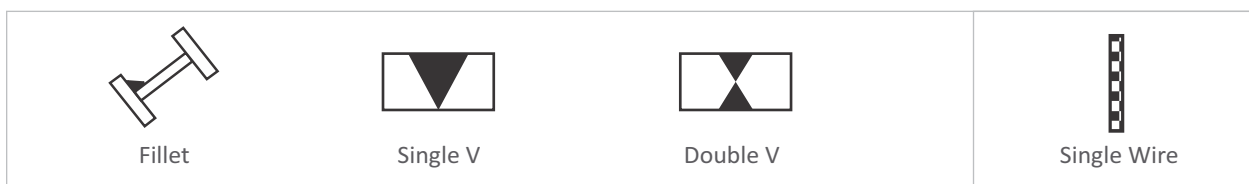
APPROVALS: RDSO, ABS, BV, DNV, IRS, LRA, MND, IBR

CLASSIFICATION :

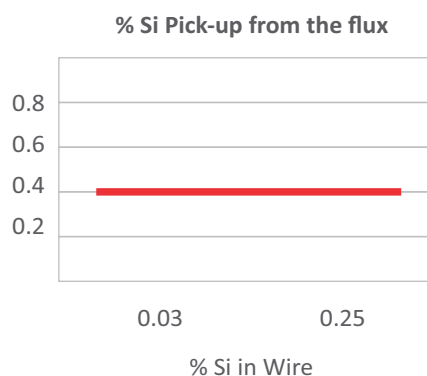
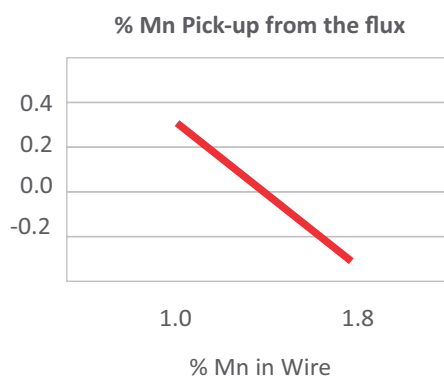
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EL8 (AUTOMELT Gr.A)	F6A2-EL8	Multi-pass
AUTOMELT EH14	F7A4/P4-EH14	Multi-pass

TYPICAL APPLICATIONS :

- General Structural Welding
- 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
15	20	30	35

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:			
With wire	C	Mn	Si
Automelt EL8 (Automelt Gr.A)	0.06	0.85	0.40
Automelt EH14	0.07	1.50	0.40

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:							
With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact		
					-20°C	-30°C	-40°C
AUTOMELT EL8 (Automelt Gr.A)	AW	470	390	28	50	-	-
Automelt EH14	AW	540	460	30	-	-	40
Automelt EH14	PW	510	430	33	-	-	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