



SAW Fluxes
AUTOMELT B41



GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity Index of 3.1
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding including two run technique
- For Carbon & Low Alloy Steels
- Suitable for Single & Multi 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 EH10K is 5

CLASSIFICATION :

With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EH11K	F7TA2-EH11K	Two Run
AUTOMELT EH10K	F7A8/P8-EH10K	Multi-pass
AUTOMELT EH12K	F7A8/P8-EH12K	Multi-pass
AUTOMELT EH14	F7A6/P6-EH14	Multi-pass
AUTOMELT EA2	F8A4-EA2-A2	Multi-pass
AUTOMELT EA4	F8A4/P4-EA4-A4	Multi-pass
AUTOMELT EA3	F8A4/P4-EA3-A3	Multi-pass
AUTOMELT ENi1	F7A6-ENi1-Ni1	Multi-pass
AUTOMELT ENi2	F7A8-ENi2-Ni2	Multi-pass
AUTOMELT ENi3	F7A10-ENi3-Ni3	Multi-pass
AUTOMELT EF1	F8A6-EF1-F1	Multi-pass
AUTOMELT EF2	F8A6-EF2-F2	Multi-pass
AUTOMELT EF3	F9A8-EF3-F3	Multi-pass

TYPICAL APPLICATIONS :

- Fabrication of Reactors, steam generators
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Pressure Vessel and Boiler
- Heavy Equipment Fabrication



APPROVALS:

IBR

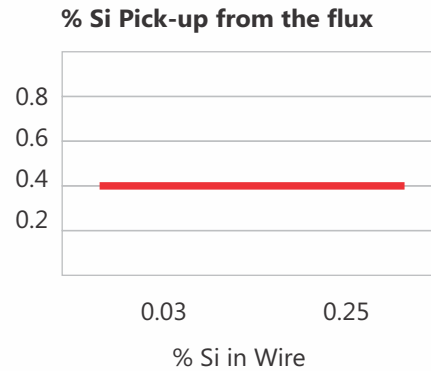
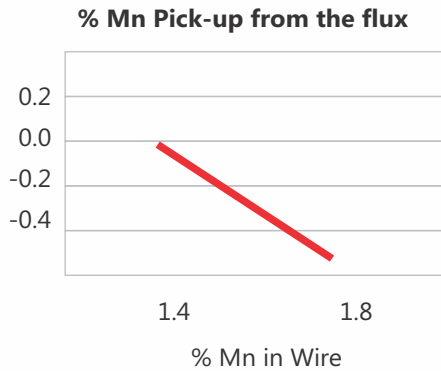
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ACTIVITY OF THE FLUX:



CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
10	35	20	30

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

With wire	C	Mn	Si	Ni	Cr	Mo
AUTOMELT EH11K	0.08	1.35	0.45	--	--	--
AUTOMELT EH10K	0.07	1.50	0.45	--	--	--
AUTOMELT EH12K	0.08	1.55	0.45	--	--	--
AUTOMELT EH14	0.08	1.55	0.30	--	--	--
AUTOMELT EA2	0.08	1.35	0.30	--	--	0.50
AUTOMELT EA4	0.08	1.50	0.30	--	--	0.50
AUTOMELT EA3	0.08	1.55	0.30	--	--	0.50
AUTOMELT ENi1	0.07	1.40	0.30	0.90	--	--
AUTOMELT ENi2	0.08	1.40	0.30	2.20	--	--
AUTOMELT ENi3	0.08	1.40	0.30	3.00	--	--
AUTOMELT EF1	0.08	1.20	0.40	1.00	--	0.45
AUTOMELT EF2	0.08	1.50	0.40	0.60	--	0.50
AUTOMELT EF3	0.08	1.50	0.40	0.90	--	0.50

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MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact		
					-40°C	-50°C	-60°C
Automelt EH11K	AW, TR	540	440	24	(50J at -30°C)		
Automelt EH10K	AW	550	440	26		60	40
Automelt EH10K	PW	530	430	28		80	60
Automelt EH12K	AW	560	450	26		80	50
Automelt EH12K	PW	540	430	27		90	60
Automelt EH14	AW	550	440	26	60	50	
Automelt EH14	PW	530	430	28	80	60	
Automelt EA2	AW	580	470	24	40		
Automelt EA2	PW	560	460	25	50		
Automelt EA4	AW	600	490	24	40		
Automelt EA4	PW	580	470	26	50		
Automelt EA3	AW	630	500	24	40		
Automelt EA3	PW	610	480	25	50		
Automelt ENi1	AW	520	430	29		50	
Automelt ENi2	AW	530	430	28		70	40
Automelt ENi3	AW	540	440	27	(40J at -70°C)	90	60
Automelt EF1	AW	580	470	25		50	
Automelt EF2	AW	600	480	25		40	
Automelt EF3	AW	650	570	22		60	40

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