



AUTOMELT B71

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 including “two-run” technique
- For Carbon & Low Alloy Steels
- Suitable for Narrow Gap Welding
- Suitable for Single & Multi Wire twin and Tandem System
- Suitable for Welding Speeds of 0.35-0.70 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / AC
- Wall Neutrality Number with EM12K Wire is 12

APPROVALS: RDSO, ABS, IBR

CLASSIFICATION :

With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EL8	F7A2-EL8	Multi-pass
AUTOMELT EL12	F7A2-EL12	Multi-pass
AUTOMELT EM12K	F7A4/P4-EM12K	Multi-pass
AUTOMELT EH10K	F7A4/P4-EH10K	Multi-pass
AUTOMELT EH12K	F7A4/P4-EH12K	Multi-pass
AUTOMELT EH14	F7A4/P4-EH14	Multi-pass
AUTOMELT EA2	F8A2/P2-EA2-A2	Multi-pass
AUTOMELT EA4	F8A2/P2-EA4-A4	Multi-pass
AUTOMELT EA3	F8A2/P2-EA3-A3	Multi-pass
AUTOMELT EB2	F8PZ-EB2-B2	Multi-pass
AUTOMELT EB3	F8PZ-EB3-B3	Multi-pass
AUTOMELT ENi1	F8A5-ENi1-Ni1	Multi-pass
AUTOMELT ENi2	F8A6-ENi2-Ni2	Multi-pass
AUTOMELT ENi3	F8A8/P10-ENi3-Ni3	Multi-pass

TYPICAL APPLICATIONS :

- General Structural Welding
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Pressure Vessel and Boiler
- Heavy Equipment Fabrication



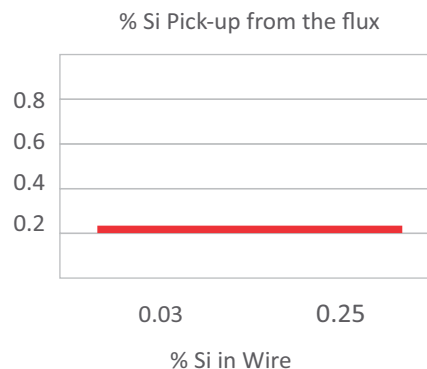
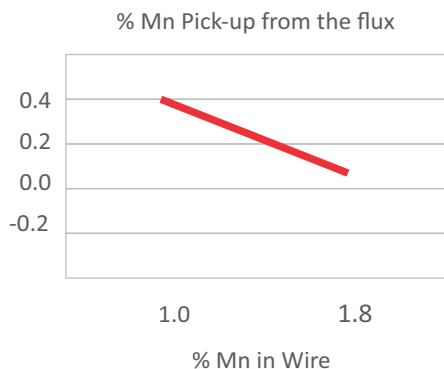
(continue...)



AUTOMELT B71

SAW Flux

ACTIVITY OF THE FLUX:



CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
15	30	30	25

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

With wire	C	Mn	Si	Ni	Cr	Mo	Other Elements
AUTOMELT EL8	0.06	0.80	0.30	-	-	-	-
AUTOMELT EL12	0.08	0.80	0.30	-	-	-	-
AUTOMELT EM12K	0.08	1.45	0.45	-	-	-	-
AUTOMELT EH10K	0.07	1.60	0.45	-	-	-	-
AUTOMELT EH12K	0.08	1.75	0.50	-	-	-	-
AUTOMELT EH14	0.08	1.90	0.40	-	-	-	-
AUTOMELT EA2	0.08	1.35	0.30	-	-	0.50	-
AUTOMELT EA4	0.08	1.50	0.30	-	-	0.50	-
AUTOMELT EA3	0.08	1.80	0.30	-	-	0.50	-
AUTOMELT EB2	0.07	1.10	0.40	-	1.10	0.50	-
AUTOMELT EB3	0.07	1.10	0.40	-	2.10	1.00	-
AUTOMELT ENi1	0.08	1.40	0.45	0.90	-	-	-
AUTOMELT ENi2	0.09	1.40	0.45	2.20	-	-	-
AUTOMELT ENi3	0.09	1.40	0.45	3.00	-	-	-

(continue...)



AUTOMELT B71

SAW Flux

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:									
With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact (J)				
					-30°C	-40°C	-50°C	-60°C	-70°C
Automelt EL8	AW	500	420	26	50		-	-	-
Automelt EL12	AW	520	430	26	50		-	-	-
Automelt EM12K	AW	530	430	26	-	50	-	-	-
Automelt EM12K	PW1	500	420	28	-	60	-	-	-
Automelt EH10K	AW	590	500	26	-	60	-	-	-
Automelt EH10K	PW1	530	460	28	-	70	-	-	-
Automelt EH12K	AW	560	450	25	-	70	-	-	-
Automelt EH12K	PW1	540	430	27	-	60	-	-	-
Automelt EH14	AW	550	440	26	-	70	-	-	-
Automelt EH14	PW1	530	430	28	-	-	-	-	-
Automelt EA2	AW	600	520	24	40	-	-	-	-
Automelt EA2	PW1	580	510	25	40	-	-	-	-
Automelt EA4	AW	660	570	24	50	-	-	-	-
Automelt EA4	PW1	650	560	26	60	-	-	-	-
Automelt EA3	AW	690	590	24	40	-	-	-	-
Automelt EA3	PW1	680	580	25	40	-	-	-	-
Automelt EB2	PW2	600	490	24	-	-	-	-	-
Automelt EB3	PW2	630	510	24	-	-	-	-	-
Automelt ENi1	AW	580	470	25	-	-	40	-	-
Automelt ENi2	AW	600	490	25	-	-	50	-	-
Automelt ENi3	AW	620	510	26	-	-	-	50	-
Automelt ENi3	PW1	600	490	27	-	-	-	-	50

AW – As Welded; PW1 – After Post weld heat treatment of 620°C for 1 hour

PW2 – After Post Weld Heat treatment of 690°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