


GENERAL DESCRIPTION:

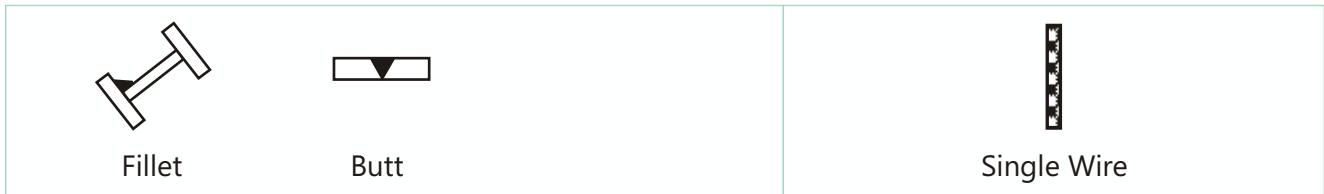
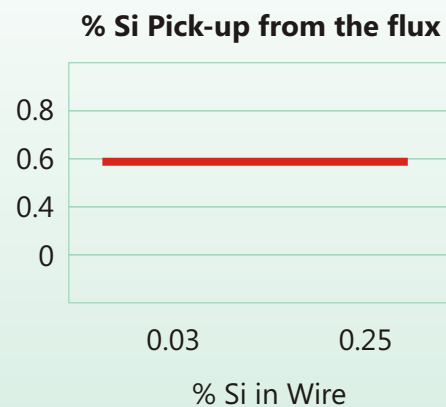
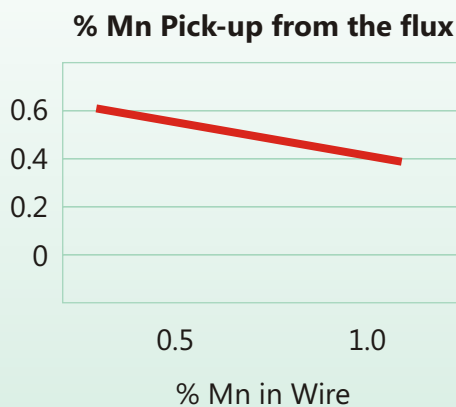
- Agglomerated Flux
- Aluminate- Rutile Type Flux
- Neutral Flux having Basicity Index of 0.9
- Active Flux with moderate Si and Mn pick-up
- For Multi-pass Butt and fillet welding
- For Carbon Steels
- Suitable for Single Wire Suitable for Welding Speeds of 0.35 – 0.60 m/min
- Grain Size – 0.25-2.00mm
- Type of Current – DCEP 800A
- Wall Neutrality Number with EL8 Wire is 50

CLASSIFICATION :

With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EL8	F7AZ/PZ-EL8	Multi-pass
AUTOMELT EL12	F7AZ/PZ-EL12	Multi-pass
AUTOMELT EM12K	F7AZ/PZ-EM12K	Limited Multi-pass

TYPICAL APPLICATIONS :

- General Structural Welding
- Fabrication of Cylinders and vessels


APPROVALS:
ACTIVITY OF THE FLUX:

CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
35	15	35	15

(continue...)



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Chemical Composition of Undiluted Weld Metal (wt%), Typical:

With wire	C	Mn	Si
Automelt EL8	0.06	1.10	0.65
Automelt EL12	0.08	1.20	0.65
Automelt EM12K	0.07	1.40	0.80

Mechanical properties of All Weld Metal, Typical:

With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact (J) 0°C
Automelt EL8	AW	530	440	25	40
Automelt EL8	PW	500	420	27	50
Automelt EL12	AW	540	450	26	40
Automelt EL12	PW	510	430	28	50
Automelt EM12K	AW	540	450	28	40
Automelt EM12K	PW	510	430	30	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