

SELECTOR CHART FOR AGGLOMERATED SUBMERGED ARC WELDING FLUXES



| TYPES | Brand Name AUTOMETLT | B I | Flux Type | A / N | Classification | Current in A max | Hi speed | Hi current | Twin wire | Tandem | Low H2 | F | SP | MP | Remarks | | |
|---------------------|-------------------------|------|--------------|-------|-----------------------|--|-----------------------|---------------|--------------|--------|-----------|---|----|----|---|---|--|
| Carbon/Alloy steels | A55 | 0.6 | AR | A | AWS 5.17 | F7AZ/F7PZ-EL8, F7A0/F7P0-EM12K | 800 | - | - | - | - | - | - | Y | Pressure vessels, Rail girders, LPG cylinders, Boilers, Earthmoving equipment | | |
| | A55 GP | 0.6 | AR | A | | F7AZ-EL8, F7AZ-EM12K | 800 | - | - | - | - | - | - | - | Y | Tolerant to rust and scale. General, Structural, Machine building, Automotives, Locomotives, etc | |
| | A55 LS | 0.6 | AR | A | | F7AZ-EL8, F7AZ-EM12K | 800 | - | - | - | - | - | - | - | Y | For welding at very low speeds < 0.3 m/min | |
| | A55 HS | 0.6 | AR | A | | F7AZ-EL8, F7AZ-EM12K | 800 | Y | - | Y | - | - | Y | Y | - | High speed welding upto 1.7 -2 m/min. | |
| | A57 | 0.6 | AR | A | | F7AZ-EL8, F7AZ-EM12K | 800 | - | - | Y | - | - | Y | Y | Y | Tolerant to rust and scale. General, Structural, Machine building, Automotives, Locomotives, etc | |
| | A61 | 1 | MnSi | A | | F7A0/P0-EL8, F7A2/P2-EM12K | 1200 | Y | Y | Y | Y | - | - | - | - | High speed welding upto 1.7 -2 m/min. | |
| | A81 | 0.6 | AR | A | AWS 5.17/ 5.23 | F7A0-EL8, F7A0-EM12K | 800 | Y | - | Y | Y | - | Y | Y | - | Relatively high speed, structural steels, boilers, pipes, fine grain steels | |
| | A 10 Plus | 0.8 | AR | A | | F6A2-EL8, F7AZ-EM12K | 1000 | - | Y | Y | Y | - | - | - | - | Pressure vessels, Pipe steels, general structural steels & Fine grain structural steels. | |
| | B16 | 1.8 | FB | A | | F7A0-EL8, F7A0-EM12K | 1200 | - | - | - | - | - | - | - | - | Good slag peeling, Pressure vessels, LPG cylinders | |
| | B21 | 3.1 | FB | N | | F7A8-EH10K, F7A4/F7P4-EH14, F8A4-EA2, F9A/P2-EA3-A3 | 1000 | - | - | Y | Y | Y | - | - | - | Boilers, Heat exchangers, Steam generator, Reactor safety tanks and for welding thick walled pressure vessels | |
| | B22 | 1.7 | FB | N | | F7A5/P5-EH10K, F7A4/F6P4- EM12K, F7A4/F7P4-EH14 | 1200 | - | Y | - | - | Y | - | - | Y | | |
| | B31 | 1.5 | AFB | N | | F7A4/P4-EH14, F8A2/F7A2-EA3-A3 | 800 | - | - | - | - | Y | - | - | - | | |
| | B41 | 3.1 | FB | N | | F7A8-EH10K | 800 | - | - | - | - | Y | - | - | - | | |
| | B71 | 1.6 | FB | N | | F7A4/F6P4-EM12K, F7A4/P4-EH14, F8A4/F7A4-EA3 | 1000 | - | - | - | - | Y | - | - | Y | | |
| | B20 Plus | 3.1 | FB | N | | F7A8-EM12K, F7A6/P8-EH10K, F7P6-EH14, F7P4-EA2 | 1000 | - | - | Y | Y | Y | - | Y | Y | | Mn Adding Flux. Best used with low Mn Wires. |
| | B21 Plus | 3.1 | FB | N | | F7A6/P8-EH10K, F7A4/P6-EH14 | 1000 | - | - | Y | Y | Y | - | Y | Y | | Best used with EH14/EH10K |
| | B41 Plus | 3.1 | FB | N | | F7A8/F6P8-EH10K | 800 | - | - | Y | Y | Y | - | Y | Y | | Nonalloying flux. |
| | B25 Plus | 2.6 | FB | N | | F7A8/F6P8-EH10K | 800 | - | - | Y | Y | Y | - | Y | Y | | Best used with Cr-Ni-Mo Wires |
| Stainless Steel | S11 | 1.8 | AFB | A | EN 760 | SA FB 2 74 Cr DC | 800 | - | - | - | - | - | - | - | Cr-compensating flux, For use with austenitic ss such as 308L,316L,347,318,309L | | |
| | S33 | 3.2 | AFB | N | | SA AF 2 54 DC | 800 | - | - | - | - | - | - | - | Non Cr-compensating flux, For use with austenitic ss such as 308L,316L,347,318,309L | | |
| | S76 | 2.7 | FB | N | | A FB 2 55 AC | 800 | - | - | - | Y | Y | - | - | For heat resistant Cr - Ni SS welding such as 308,308L,347,316,316L,410,430 | | |
| | S79 | 2.7 | FB | N | | AC8MHP5 | 800 | - | - | - | - | Y | - | - | - | For 9% Ni for cryogenic applications, Ni base alloys such as NiCrMo3 | |
| | H25 | 0.7 | CaSi | A | | EN 760 | SA CS 3 97 C Cr Mo DC | 800 | - | - | - | - | - | - | - | - | Upto 260BHN |
| H35 | 0.7 | CaSi | A | 800 | - | | | - | - | - | - | - | - | - | - | Upto 360BHN | |
| H45 | 0.7 | CaSi | A | 800 | - | | | - | - | - | - | - | - | - | - | Upto 460BHN | |
| Hard Facing | H55 | 0.7 | CaSi | A | SA CS 3 97 C Cr Mo DC | | | 800 | - | - | - | - | - | - | - | - | Upto 560BHN |
| | | | | | | | | 800 | - | - | - | - | - | - | - | - | Upto 460BHN |

AR: Aluminate - Rutile, MnSi: Manganese-Silicate, FB: Fluoride - basic, AFB: Aluminate Fluoride-basic, CaSi: Calcium- Silicate, A: Active, N: Neutral, F: Fillet, SP: Single pass, MP: Multi pass, Y: Yes.
All Fluxes can be used in AC / DC(+), except B 41 Plus, which can be used only in DC.



WELDERS TO THE NATION
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