



AUTOMELT A81

SAW Flux

GENERAL DESCRIPTION:

- Agglomerated Flux
- Aluminate- Rutile Type Flux
- Acidic Flux having Basicity Index of 0.6
- Active Flux with moderate Si and Mn pick-up
- For Single and Multi-pass Butt and fillet welding at high speeds
- For C-Mn & Low Alloy Steels
- Suitable for Single and Multi-Wire, twin wire system
- Suitable for Welding Speeds of 0.40-1.20 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / AC 1000A
- Wall Neutrality Number with EM12K Wire is 56

APPROVALS: IBR

CLASSIFICATION :

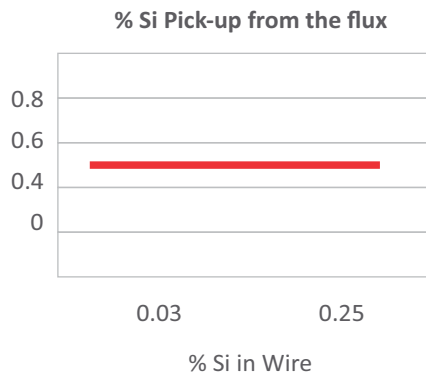
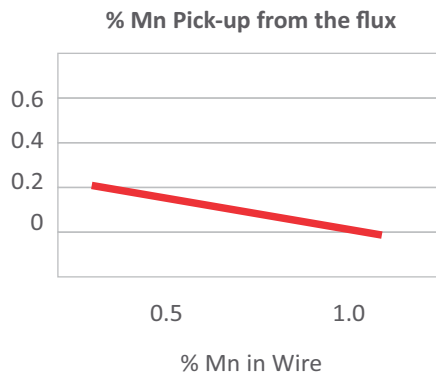
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EM12K	F7AZ-EM12K	Limited Multi-pass
AUTOMELT EA2	F8AZ-EA2-A2	Limited Multi-pass
AUTOMELT EA4	F8AZ-EA4-A4	Limited Multi-pass
AUTOMELT EB2	F9PZ-EB2-B2	Limited Multi-pass
AUTOMELT EB3	F9PZ-EB3-B3	Limited Multi-pass

TYPICAL APPLICATIONS :

- High Speed Butt & Fillet Welding
- Tube to Plate Joint
- Fabrication of H & I Beams
- Fabrication of Boilers



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
25	10	50	10

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

With wire	C	Mn	Si	Cr	Mo
Automelt EM12K	0.07	1.20	0.70	--	--
Automelt EA2	0.06	1.20	0.70	--	0.50
Automelt EA4	0.06	1.50	0.70	--	0.50
Automelt EB2	0.06	1.15	0.70	1.10	0.50
Automelt EB3	0.06	1.15	0.70	2.10	1.00

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	YS, MPa	% E
Automelt EM12K	AW	540	430	26
Automelt EA2	AW	570	500	23
Automelt EA4	AW	600	520	23
Automelt EB2	PW	640	570	20
Automelt EB3	PW	700	600	19

AW – As Welded; PW – 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