



# AUTOMELT ES1

## SAW Flux

### GENERAL DESCRIPTION :

- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity index of 4
- Excellent slag removal
- Good Wetting
- Very high deposition rates
- Cladding and Overlaying
- For Electroslag Strip Cladding
- Grain Size – 0.25-1.00 mm
- Type of Current – DCEP
- Low dilution

### TYPICAL APPLICATIONS :

- For cladding and overlaying of Stainless Steel using Electroslag Strip Cladding process



### CHEMICAL COMPOSITION OF FLUX:

$Al_2O_3 + MnO$	$CaF_2$	$CaO + MgO$
20	75	05

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

Base Metal – ASTM 516 Gr 70

Strip Dimensions – 60 mm (width) x 0.5mm (thickness)

With wire	Layer	C	Mn	Si	Cr	Ni	Mo	Nb
Subinox EQ309L	Strip	0.020	1.60	0.40	23.30	12.90	-	-
	1	0.020	1.40	0.45	21.30	12.30	-	-
Subinox EQ316L	Strip	0.020	1.60	0.40	19.00	12.50	2.50	-
	1	0.020	1.40	0.45	18.00	12.00	2.50	-
Subinox EQ347	Strip	0.020	1.65	0.40	19.50	10.70	-	0.50
	1	0.020	1.50	0.50	18.00	10.30	-	0.35
	2 (1 <sup>st</sup> layer with EQ309L)	0.020	1.50	0.50	19.50	11.00	-	0.35

The chemistry will depend on actual strip chemistry and welding parameters