AUTOMELT S79

SAW Flux

GENERAL DESCRIPTION :

- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity index of 3.1
- Neutral Behaviour to Manganese and Silicon
- Non-Chromium Compensating
- Chromium Burnout is very less
- Multi-pass Butt and Fillet Welding
- For welding of 9% Ni Steels
- Suitable for Welding Speeds of 0.40 – 0.60 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / AC

CLASSIFICATION :

With Wire	AWS 5.39	Single / Multi-pass
AUTOMELT NiCr3	F80AZ-ERNiCr-3/NiCr-3	Multi-pass
AUTOMELT NiCrMo3	F110A32-ERNiCrMo-3/NiCrMo-3	Multi-pass
AUTOMELT NiCrMo4	F100A32-ERNiCrMo-4/NiCrMo-4	Multi-pass

TYPICAL APPLICATIONS :

- ASTM class 1, SA-353 class1. For welding of 9% Nickel steels for cryogenic applications, especially LNG storage systems
- Welding on stainless / heat resistant cryogenic steels and alloys for welding nickel base alloys.

Fillet

Single V

Double V

Single Wire

CHEMICAL COMPOSITION OF FLUX:

SiO_2 + TiO_2	Al_2O_3 + MnO	CaF_2
15	35	50

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

With wire	C	Mn	Si	Cr	Ni	Mo	Other Elements
Automelt NiCr3	0.01	2.80	0.30	20.0	Rem	8.6	Fe-0.4; Nb-2.4
Automelt NiCrMo3	0.03	0.30	0.30	22.0	Rem	8.6	Fe-4.0; Nb-3.5
Automelt NiCrMo4	0.01	0.55	0.15	14.6	Rem	16.0	Fe-5.0; W-3.6; Co-0.2; Cu-0.01

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	% E	CVN Impact (J) -196°C
Automelt NiCr3	AW	620	35	-
Automelt NiCrMo3	AW	780	35	50
Automelt NiCrMo4	AW	750	35	50

AW – As Welded

The chemistry and mechanical properties will depend on actual wire chemistry and arc voltage

Available in Standard packing of 30 Kg Bag