



# AUTOMELT A55 (AUTOMELT Gr II)

## 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 (With EM12K Wire restrict to 15 mm thickness for multi-pass)
- For Carbon Steels
- Suitable for Single Wire & Tandem System
- Suitable for Welding Speeds of 0.35-0.60 m/min
- Grain Size – 0.25-2.00 mm
- Type of Current – DCEP / AC 800A
- Wall Neutrality Number with EL8 Wire is 56

**APPROVALS:** RDSO, ABS, BV, DNV, IRS, LRA, MND, IBR

### CLASSIFICATION :

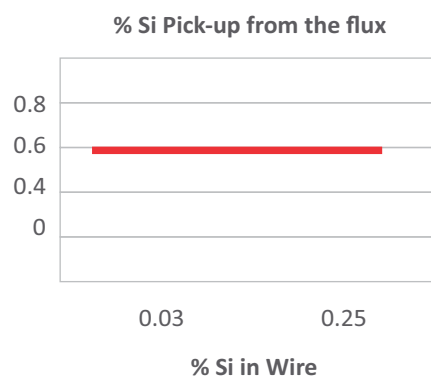
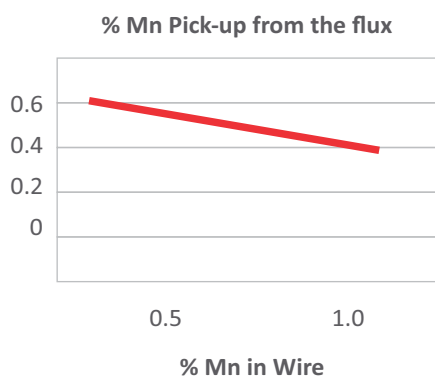
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EL8 (AUTOMELT Gr.A)	F7AZ/PZ-EL8	Multi-pass
AUTOMELT EL12	F7AZ/PZ-EL12	Multi-pass
AUTOMELT EM12K	F7A0/P0-EM12K	Limited Multi-pass
AUTOMELT EH11K	F7AZ-EH11K	Single Pass

### TYPICAL APPLICATIONS :

- General Structural Welding
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Cylinders and vessels



### ACTIVITY OF THE FLUX:



(continue...)



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CHEMICAL COMPOSITION OF FLUX:			
SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>
30	10	45	15

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:			
With wire	C	Mn	Si
Automelt EL8 (Automelt GrA)	0.06	1.10	0.65
Automelt EL12	0.08	1.20	0.65
Automelt EM12K	0.07	1.40	0.80
Automelt EH11K	0.07	1.80	1.10

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:						
With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact	
					0°C	-20°C
Automelt EL8 (Automelt Gr.A)	AW	530	440	25	50	--
Automelt EL8	PW	500	420	27	60	--
Automelt EL12	AW	540	450	26	50	--
Automelt EL12	PW	510	430	28	60	--
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

Available in Standard packing of 30 Kg Bag