



AUTOMELT A82

SAW Flux

GENERAL DESCRIPTION:

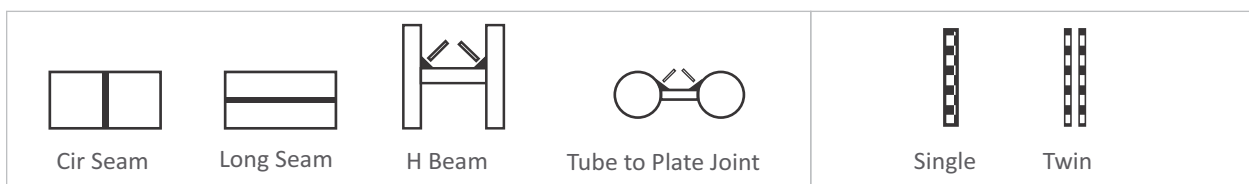
- Agglomerated Flux
- Aluminate- Rutile Type Flux
- Acidic Flux having Basicity Index of 0.6
- Active Flux with moderate Si and Mn pick-up
- For Single and Multi-pass Butt and fillet welding at very high speeds
- For C-Mn Steels
- Suitable for Single and twin Wire system
- Suitable for Welding Speeds of 0.40-1.80 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DC / AC 1000A
- Wall Neutrality Number with EM12K Wire is 85

CLASSIFICATION :

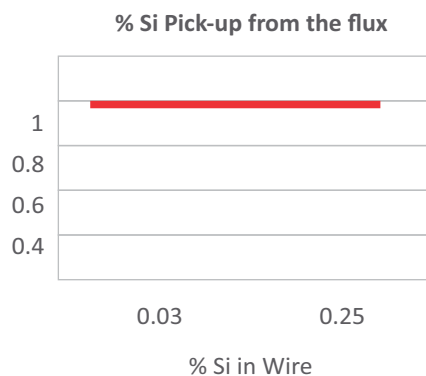
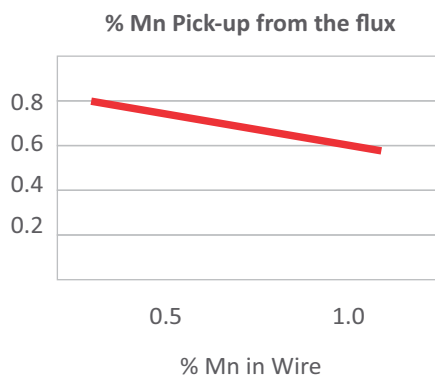
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EL8	F7AZ-EL8	Limited Multi-pass
AUTOMELT EL12	F7AZ-EL12	Limited Multi-pass
AUTOMELT EM12K	F7AZ-EM12K	Limited Multi-pass

TYPICAL APPLICATIONS :

- Structural Welding
- High Speed Fillet Welding
- Fabrication of H & I Beams
- Fabrication of Boilers, Cylinders



ACTIVITY OF THE FLUX:



(continue...)



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CHEMICAL COMPOSITION OF FLUX:

$\text{SiO}_2 + \text{TiO}_2$	$\text{CaO} + \text{MgO}$	$\text{Al}_2\text{O}_3 + \text{MnO}$	CaF_2
25	10	50	10

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

With wire	C	Mn	Si
Automelt EL8	0.06	1.20	1.00
Automelt EL12	0.07	1.20	1.00
Automelt EM12K	0.06	1.60	1.30

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	YS, MPa	% E
Automelt EL8	AW	550	460	22
Automelt EL12	AW	560	460	23
Automelt EM12K	AW	560	470	23

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