



AUTOMELT B41

SAW Flux

GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity Index of 3.1
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding including two run technique
- For Carbon & Low Alloy Steels
- Suitable for Single & Multi Wire Tandem System
- Suitable for Welding Speeds of 0.40 – 0.60 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / AC
- Wall Neutrality Number with EH10K is 5

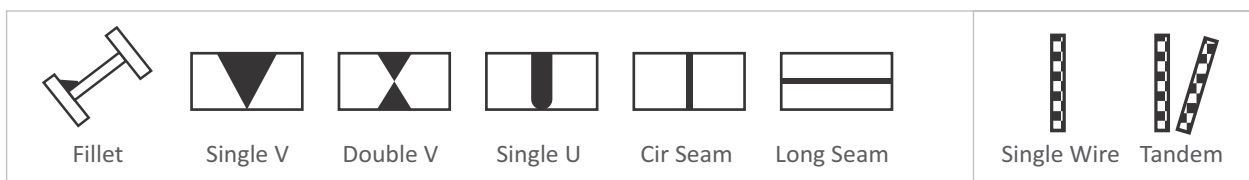
APPROVALS: IBR

CLASSIFICATION :

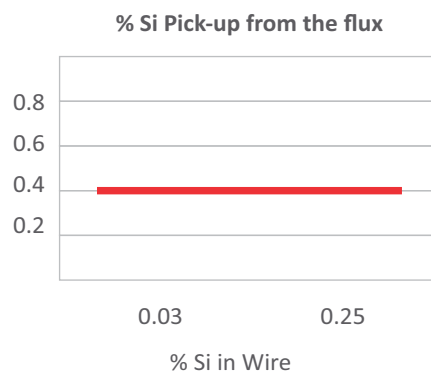
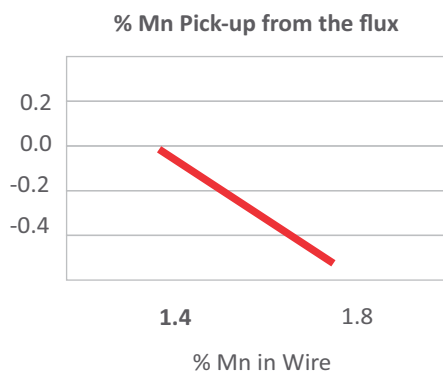
With Wire	AWS 5.17/5.23	Single / Multi-pass
AUTOMELT EH10K	F7A8/P8-EH10K	Multi-pass
AUTOMELT EH12K	F7A8/P8-EH12K	Multi-pass
AUTOMELT EH14	F7A6/P6-EH14	Multi-pass
AUTOMELT EA2	F8A4-EA2-A2	Multi-pass
AUTOMELT EA4	F8A4/P4-EA4-A4	Multi-pass
AUTOMELT EA3	F8A4/P4-EA3-A3	Multi-pass
AUTOMELT EF3	F11A4-EF3-F3	Multi-pass

TYPICAL APPLICATIONS :

- Fabrication of Reactors, steam generators
- Long Seam and Cir Seam Welding of Pipes
- Fabrication of Pressure Vessel and Boiler
- Heavy Equipment Fabrication



ACTIVITY OF THE FLUX:



(continue...)



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SAW Flux

CHEMICAL COMPOSITION OF FLUX:			
SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
10	35	20	30

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:							
With wire	C	Mn	Si	Ni	Cr	Mo	
AUTOMELT EH10K	0.07	1.50	0.45	-	-	-	
AUTOMELT EH12K	0.08	1.60	0.45	-	-	-	
AUTOMELT EH14	0.08	1.80	0.40	-	-	-	
AUTOMELT EA2	0.08	1.35	0.30	-	-	0.50	
AUTOMELT EA4	0.08	1.50	0.30	-	-	0.50	
AUTOMELT EA3	0.08	1.80	0.30	-	-	0.50	
AUTOMELT EF3	0.08	1.80	0.40	0.90	-	0.50	

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:							
With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact		
					-40°C	-50°C	-60°C
Automelt EH10K	AW	550	440	26	-	60	-
Automelt EH10K	PW	530	430	28	-	80	-
Automelt EH12K	AW	560	450	26	-	80	50
Automelt EH12K	PW	540	430	27	-	90	60
Automelt EH14	AW	550	440	26	60	50	-
Automelt EH14	PW	530	430	28	80	60	-
Automelt EA2	AW	580	470	24	40	-	-
Automelt EA2	PW	560	460	25	50	-	-
Automelt EA4	AW	600	490	24	40	-	-
Automelt EA4	PW	580	470	26	50	-	-
Automelt EA3	AW	630	500	24	40	-	-
Automelt EA3	PW	610	480	25	50	-	-
Automelt EF3	AW	770	680	19	40	-	-

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