



AUTOMELT B43

SAW Flux

GENERAL DESCRIPTION:

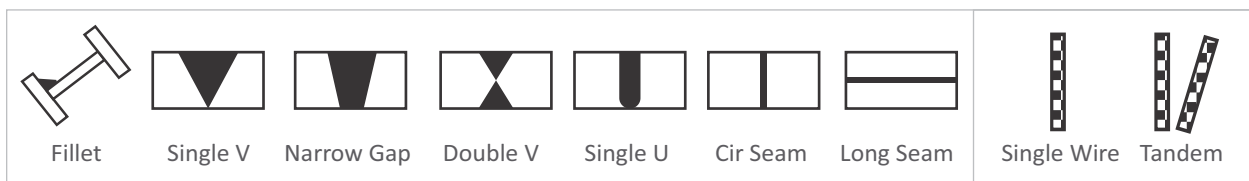
- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity index of 3.1
- Neutral behaviour to activity
- Multi-pass Butt and Fillet Welding
- For Low Alloy Steels
- Suitable for Narrow Gap Welding
- Suitable for Single & Multi Wire Tandem System
- Suitable for Welding Speeds of 0.40 – 0.60 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / AC
- Produces weld metal with low P

CLASSIFICATION :

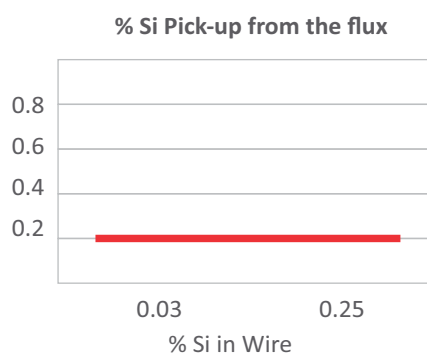
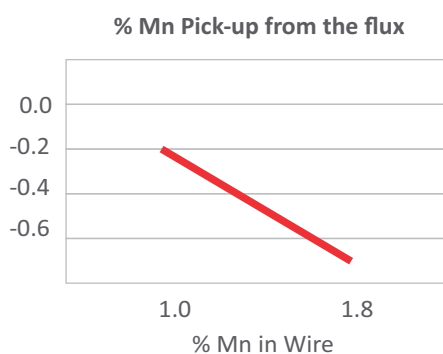
With Wire	AWS 5.17/5.23	Single/Multi-pass
AUTOMELT ENi1	F7A6-ENi1-Ni1	Multi-pass
AUTOMELT ENi2	F7A8-ENi2-Ni2	Multi-pass
AUTOMELT ENi3	F7A10/P10-ENi3-Ni3	Multi-pass
AUTOMELT ENi5	F9A4-ENi5-Ni5	Multi-pass

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:



CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	Al ₂ O ₃ + MnO	CaF ₂
10	35	50

(continue...)



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CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:					
With wire	C	Mn	Si	Ni	Mo
AUTOMELT ENi1	0.05	0.80	0.30	0.90	-
AUTOMELT ENi2	0.05	0.80	0.30	2.20	-
AUTOMELT ENi3	0.05	0.80	0.30	3.20	-
AUTOMELT ENi5	0.05	1.10	0.30	1.00	0.20

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:							
With wire	Condition	UTS, MPa	YS, MPa	% E	CVN Impact (J)		
					-50°C	-60°C	-70°C
Automelt ENi1	AW	520	430	29	50	-	-
Automelt ENi2	AW	530	430	28	70	40	-
Automelt ENi3	AW	590	500	28	90	60	30
Automelt ENi3	PW	560	480	30	100	70	40
Automelt ENi5	AW	650	570	20	40 (at -40°C)		

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