



# AUTOMELT S33

SAW Flux

## GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- High Basic Flux having Basicity Index of 3.1
- Neutral Behaviour to Carbon, so Low C weld metal is produced with Low C Wire
- Non-Chromium Compensating
- Chromium Burnout is very less
- Multi-pass Butt and Fillet Welding
- For Stainless Steels
- Suitable for Welding Speeds of 0.40 – 0.60 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP

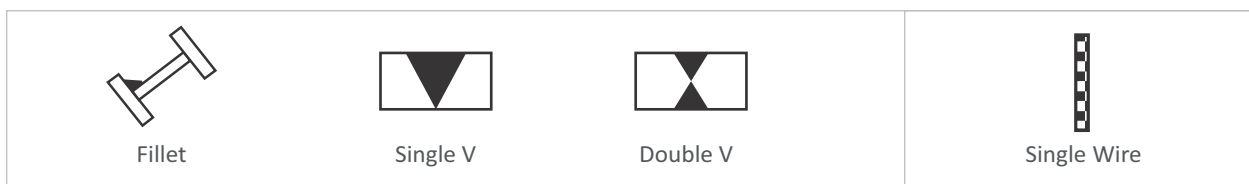
**APPROVALS:** ABS

## CLASSIFICATION :

With Wire	AWS 5.39	Single/Multi-pass
Subinox 308L	F75A6-ER308L/308L	Multi-pass
Subinox 308L Spl	F75A32-ER308L/308L	Multi-pass
Subinox 308H	F80AZ-ER308H/308	Multi-pass
Subinox 316L	F75A32-ER316L/316L	Multi-pass
Subinox 347	F75A6-ER347/347	Multi-pass
Subinox 309L	F75A6-ER309L/309L	Multi-pass
Subinox 309LMo	F75A6-ER309LMo/309LMo	Multi-pass
Subinox 410NiMo	F110AZ-ER410NiMo/410NiMo	Multi-pass
Subinox 2209	F100A4-ER2209/2209	Multi-pass
Subinox 2594	F110A2-ER2594/2594	Multi-pass

## TYPICAL APPLICATIONS :

- Welding of High Alloy Stainless steels including Duplex and Superduplex Stainless Steels
- Most suitable for welding Cryogenic Vessels



## CHEMICAL COMPOSITION OF FLUX:

SiO <sub>2</sub> + TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>
10	35	50



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CHEMICAL COMPOSITION OF UNDILUTED WELD METAL (Wt%), TYPICAL:							
With wire	C	Mn	Si	Cr	Ni	Mo	Other Elements
Subinox 308L	0.025	1.40	0.50	19.5	9.3	-	-
Subinox 308L Spl	0.025	1.40	0.50	19.5	9.7	-	-
Subinox 308H	0.05	1.40	0.50	19.5	9.2	-	-
Subinox 316L	0.025	1.40	0.50	18.5	11.5	2.3	-
Subinox 347	0.050	1.40	0.50	19.5	9.5	-	Nb + Ta – 0.50
Subinox 309L	0.025	1.40	0.50	23.5	12.5	-	-
Subinox 309LMO	0.025	1.40	0.50	23.5	12.2	2.2	-
Subinox 410NiMo	0.03	0.50	0.30	12.5	4.5	0.50	-
Subinox 2209	0.025	1.30	0.50	22.0	9.0	3.5	N – 0.12
Subinox 2594	0.025	0.60	0.50	24.5	8.5	-	N-0.25, W-0.1

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:					
With wire	Condition	UTS, MPa	% El.	CVN Impact	
				-50°C	-196°C
Subinox 308L	AW	580	37	90	-
Subinox 308L Spl	AW	580	37	-	50
SUBINOX 308H	AW	600	37	-	-
Subinox 316L	AW	580	37	90	40
Subinox 347	AW	600	35	90	-
Subinox 309L	AW	600	35	90	-
SUBINOX 309LMO	AW	620	35	-	-
Subinox 410NiMo	AW	770	23	50	-
Subinox 2209	AW	780	27	70	-
Subinox 2594	AW	650	27	70	-

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