



AUTOMELT S76

SAW Flux

GENERAL DESCRIPTION:

- Agglomerated Flux
- Fluoride-Basic Type Flux
- Neutral Flux having Basicity Index of 1.2
- It compensates Chromium to counteract arc loss
- For Cladding of Stainless Steels
- Suitable for Welding Speeds of 0.40-0.60 m/min
- Grain Size – 0.25-1.60 mm
- Type of Current – DCEP / DCEN

APPROVALS: BHEL

CLASSIFICATION :

With Wire	AWS 5.39	Single/Multi-pass
Subinox 410	SACLAD2-ER410/410	Multi-pass
Subinox 430	SACLAD2-ER430/430	Multi-pass

TYPICAL APPLICATIONS :

- Cladding of Stainless Steels

CHEMICAL COMPOSITION OF FLUX:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
30%	20	20	50

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

With wire	C	Mn	Si	Cr	Ni	Mo	Other Elements
Subinox 410	0.03	0.50	0.30	12.5	-	-	-
Subinox 430	0.03	0.40	0.50	16.2	-	-	-

MECHANICAL PROPERTIES OF ALL WELD METAL, TYPICAL:

With wire	Condition	UTS, MPa	% E
Subinox 410	AW	700	25
Subinox 430	AW	700	25

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