

# AUTOMELT A10 PLUS

## AWS Classifications:

With wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F6A2 - EL8	F43A3 - EL8
Automelt EM12K	F7AZ - EM12K	F48A0 - EM12K

## Characteristics:

Automelt A10 Plus is a special agglomerated Aluminate-basic type flux best suited for welding general structural steels. Average manganese and silicon pickup results with this flux, which makes it useful for welding it with wires like EL8. The weld metal produced is excellently resistance to cracking and can to a great extent compensate for contamination of base metal. It gives good impact values with EL8 wire, even though it is acidic in nature. It can be welded on DC upto 1000A. The flux can be used with single wire and multi-wire welding.

Basicity	Grain Size (mm)
0.8*	0.25-1.60

\*-As per Boniszewski

## Flux Analysis:

SiO <sub>2</sub> + TiO <sub>2</sub>	CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>
45 %	25 %	10 %	20 %

## All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P
Automelt EL8	0.06	1.25	0.55	0.020 max	<0.025
Automelt EM12K	0.06	1.50	0.65	0.020 max	<0.025

## All weld metal properties:

With wire	Condition	UTS Mpa	YS MPa	% Elongation (L=4d)	CVN Impact (J)		
					0 °C	-20°C	-30°C
Automelt EL8	AW	>430	>350	>22	--	>60	>40
Automelt EM12K	AW	>480	>400	>22	>40	--	--

AW As Welded;

## Typical Applications:

For welding of General Structural Steels, Pipe steels, Pressure Vessel Steels, Fine Grained Structural Steels

Current / polarity: DC (+)

Redrying Conditions: It is advisable to dry the flux at 300-350°C for 1 Hr prior to use

## Packing Data

	Net Wt. Kgs.
Poly lined paper bags (Standard)	30
Steel Drums (on demand)	100



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