

AUTOMELT A55 GP

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F7AZ - EL8	F48AO - EL8
Automelt EM12K	F7AZ - EM12K	F48AO - EM12K

Characteristics:

Automelt A55GP is General purpose Aluminate-Rutile type of submerged arc welding flux. It is active flux with moderate Si and Mn pickup. It gives X-ray quality welds with smooth & shiny weld bead. The slag is very easy to remove, even for root runs.

Basicity	Wall Neutrality No.	Grain Size (mm)
0.6*	50	0.25-2.00

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
25 %	10 %	50 %	10 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P
Automelt EL8	0.06	0.90	0.60	<0.03	<0.03
Automelt EM12K	0.06	1.10	0.70	<0.03	<0.03

All weld metal properties:

With wire	Condition	UTS	YS	% Elongation	CVN Impact (J)
		Mpa	MPa	(L=4d)	0° C
Automelt EL8	AW	>480	>400	>24	>30
Automelt EM12K	AW	>480	>400	>24	>30

AW - As Welded

Type of current / polarity: DC (+)

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

Typical Applications:

Welding structural, machine building, automobiles, locomotives, earth-moving equipments, rail girders, crane wheels, Pipes etc. With EM12K wire restrict to 15mm thickness for multi-pass welds.

Packing Data

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



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