

AUTOMELT A55

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F7AZ/PZ- EL8	F48A0/P0 - EL8
Automelt EM12K	F7A0/P0 - EM12K	F48A2/P2 - EM12K

Approvals: ABS, BV, DNV, IRS, LRA, MND

Characteristics:

Automelt A55 is all 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. This is acidic flux considered ideal for starting up with SAW welding.

Basicity	Wall Neutrality No.	Grain Size (mm)
0.6*	56	0.25-2.00

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
30 %	10 %	45 %	15 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P
Automelt EL8	0.06	1.10	0.65	<0.025	<0.03
Automelt EM12K	0.07	1.40	0.80	<0.025	<0.03

All weld metal properties:

With wire	Condition	UTS Mpa	YS MPa	% Elongation (L=4d)	CVN Impact (J)	
					0 °C	-20 °C
Automelt EL8	AW	>510	>420	>24	>50	>30
Automelt EL8	PW	>480	>400	>24	--	>50
Automelt EM12K	AW	>525	>420	>24	--	--
Automelt EM12K	PW	>480	>400	>24	>50	>30

AW - As Welded; PW - After Post weld heat treatment of 620 °C for 1 hour

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, pressure vessels and boilers, machine building, automobiles, locomotives, earth-moving equipments, rail girders, crane wheels, LPG cylinders, 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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