

AUTOMELT A57

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F7AZ - EL8	F48A0 - EL8
Automelt EM12K	F7AZ - EM12K	F48A0 - EM12K

Characteristics:

Automelt A57 is all purpose Aluminate-Rutile type of submerged arc welding flux. It is active flux with medium 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. It is resistant to rust, scale, porosity. It can work on a wide range of welding parameters.

Basicity	Wall Neutrality No.	Grain Size (mm)
0.5*	60	0.25-1.60

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
25 %	10 %	55 %	5 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P
Automelt EL8	0.07	1.00	0.70	<0.03	<0.03
Automelt EM12K	0.07	1.30	0.80	<0.03	<0.03

All weld metal properties:

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

AW - As Welded

Type of current / polarity: DC (+) 800A max.

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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