

AUTOMELT A82

AWS 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 A82 is Acidic Aluminate-rutile type of submerged arc welding of structural steels. It is active flux with high Si and Mn pickup. This is particularly suited with twin wire system at high speed. It is preferably used for thin sheet fillet welding and single pass welding from both sides.

Basicity	Wall Neutrality No.	Grain Size (mm)
0.6*	56	0.25-1.00

*-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	1.20	1.00	<0.03	<0.03
Automelt EM12K	0.06	1.60	1.30	<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	>510	>420	>24	>30

AW As Welded;

Typical Applications:

For Fillet welding of thin (4-6mm) structural Steels H beams & I beams

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

Packing Data

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



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