

AUTOMELT B20 PLUS

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EM12K	F7A8-EM12K	F48A6-EM12K
Automelt EH10K	F7A6/P8- EH10K	F48A5/P6 - EH10K
Automelt EA2	F8P4 - EA2 - A2	F55P4 - EA2 - A2

Characteristics

Automelt B20 Plus is a special agglomerated fluoride-basic type flux. On account of the Manganese pick-up, it can be used with wires with low manganese content. This flux is highly suited to tandem, multi-wire and twin-wire welding and produces a weld metal with very good toughness and crack resistance.

Basicity	Grain Size (mm)
3.1*	0.25-1.60

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
15 %	30 %	20 %	30 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P	Mo
Automelt EM12K	0.07	1.20	0.45	<0.015	<0.025	--
Automelt EH10K	0.08	1.60	0.45	<0.015	<0.025	--
Automelt EA2	0.08	1.30	0.35	<0.015	<0.025	0.45

All Weld Metal Mechanical Properties:

With AWL wires	Condition	UTS MPa	YS MPa	E% (l=4Xd)	CVN Impact, J			
					-20 °C	-40 °C	-50 °C	-60 °C
Automelt EM12K	AW	>480	>400	>24	--	>100	>60	>40
Automelt EH10K	AW	>480	>400	>24	--	>80	>60	--
Automelt EH10K	PWHT	>480	>400	>24	--	>100	>80	>60
Automelt EH14	PWHT	>480	>400	>24	--	>80	>60	--
Automelt EA2	PWHT	>550	>450	>22	>80	>40	--	--

AW - As Welded; PW - 620 °C for 1 Hr

Typical Applications:

For Welding of Fine grained structural steels, General structural steels, Pressure Vessel Steels, Pipe Steels and heat resistant steels.

Current Condition: AC; DC(+)

Redrying Conditions: Damp flux to be re-dried at 250 °C for 1 hr.

Packing Data

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



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