

AUTOMELT B22

AWS Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F6A2 - EL8	F43A3 - EL8
Automelt EM12K	F7A2/F6P4 - EM12K	F48A3/F43P4 - EM12K
Automelt EH10K	F7A4/P4 - EH10K	F48A4/P4 - EH10K
Automelt EH14	F7A4/P4 - EH14	F48A4/P4 - EH14

Characteristics:

Automelt B22 is an agglomerated SAW Flux of fluoride Basic type for high current capacity welding. It offers X-ray quality welding with good impact strength at subzero temperature. It is suitable for all C-Mn and LA steel wires.

Basicity	Wall Neutrality No.	Grain Size (mm)
1.7*	16	0.25-1.60

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
20 %	30 %	25 %	20 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P
Automelt EL8	0.06	0.80	0.30	<0.03	<0.03
Automelt EM12K	0.06	1.20	0.40	<0.03	<0.03
Automelt EH10K	0.06	1.30	0.40	<0.03	<0.03
Automelt EH14	0.07	1.50	0.30	<0.03	<0.03

All weld metal properties:

With wire	Condition	UTS Mpa	YS MPa	% Elongation (L=4d)	CVN Impact (J)		
					-20°C	-30°C	-40°C
Automelt EL8	AW	>430	>330	>24	>40	>30	--
Automelt EM12K	AW	>510	>420	>24	>50	>40	--
Automelt EM12K	PW	>450	>350	>24	>60	>50	>30
Automelt EH10K	AW	>510	>420	>24	--	>50	>30
Automelt EH10K	PW	>480	>400	>24	--	>60	>40
Automelt EH14	AW	>510	>420	>24	--	>60	>40
Automelt EH14	PW	>480	>400	>24	--	>60	>50

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

Typical Applications:

Automelt B22 is suitable for Submerged arc twin wire, tandem and multi wire welding as well as welding with the two-run technique e.g. in the production of large pipes. The high current carrying capacity also makes it suitable for fillets with a large throat thickness in steel construction. This flux is also recommended with all hardfacing flux cored wires.

Packing Data

Net Wt. Kgs.

Poly lined paper bags (Standard)	30
Steel Drums (on demand)	100



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