

AUTOMELT B25 PLUS

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EH10K	F7A8/F6P8 - EH10K	F48A6/F43P6 - EH10K
Automelt EB2	F8A2/F7P2-EB2-B2	F55A3/F49P3-EB2-B2

Characteristics

Automelt B25 plus is a special agglomerated fluoride-basic type flux best suited for welding heat-resistant steels. Exceptionally low silicon pickup and neutral behavior in terms of manganese are typical of the metallurgical properties of the flux. It can be welded on DC and AC at upto 800A. The flux can be welded with twin wire process and can also be used for tandem welding with two or more wire electrodes. Lower flux density of this flux results in lower consumption rate.

Basicity*	Grain Size (mm)
2.6	0.25-1.60

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
15 %	40 %	20 %	25 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P	Mo	Cr
Automelt EH10K	0.06	1.10	0.30	<0.015	<0.025	--	--
Automelt EB2	0.06	0.65	0.20	<0.015	<0.025	0.45	1.10

All Weld Metal Mechanical Properties:

With AWL wires	Condition	UTS MPa	YS MPa	E% (l=4Xd)	CVN Impact, J			
					-20 °C	-30 °C	-50 °C	-60 °C
Automelt EH10K	AW	>480	>400	>24	--	--	100 min	80 min
Automelt EH10K	PWHT*	>450	>350	>24	--	--	120 min	100 min
Automelt EB2	AW	>550	>470	>20	>60	>40	--	--
Automelt EB2	PWHT**	>490	>400	>22	>60	>40	--	--

AW - As Welded; PWHT*-620 °C for 1 Hr; PWHT** : 690 °C for 1 Hrs

Typical Applications:

Hear Resistant Steels : 15 Mo 3, 13 Cr Mo 44, 15 Cr Mo 9 10, 10 Cr Mo 9 10, 12 Cr Mo 19 5, X 20 Cr Mo V 12 1, X 20 Cr Mo V W 12 1

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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