AUTOMELT B71

AWS Classifications:		
With Wire	**AWS 5.17/5.23**	**AWS 5.17M/5.23M**
Automelt EM12K	F7A4/F6P4 - EM12K	F48A4/F42P4 - EM12K
Automelt EH14	F7A4/P4 - EH14	F48A4/P4 - EH14
Automelt EA2	F7A4 - EA2-A2	F49A4 - EA2-A2
Automelt EA3	F8A4/F7P4 - EA3-A3	F55A4/F49P4 - EA3-A3

Approvals: ABS, RDSO

Characteristics:

Automelt B71 is Fluoride-basic type of submerged arc welding flux. It is neutral flux. It gives X-ray quality welds with good impact properties. It is ideal for welding of thick-walled vessels.

Basicity	Wall Neutrality No.	Grain Size (mm)
1.6*	23	0.25-1.60

*-As per Boniszewski

Flux Analysis:

$SiO_2 + TiO_2$	CaO + MgO	$Al_2O_3 + MnO$	CaF_2
15 %	30 %	30 %	25 %

All Weld Metal Chemistry, wt% (Typical):						
With wire	C	Mn	Si	S	P	Mo
Automelt EM12K	0.07	1.20	0.40	<0.03	<0.03	-
Automelt EH14	0.07	1.50	0.30	<0.03	<0.03	-
Automelt EA2	0.07	1.20	0.30	<0.03	<0.03	0.45
Automelt EA3	0.07	1.60	0.35	<0.03	<0.03	0.45

All weld metal properties:						
With wire	Condition	UTS	YS	% Elongation	CVN Impact (J)	
		Mpa	MPa	(L=4d)	-30°C	-40°C
Automelt EM12K	AW	>510	>420	>24	>50	>40
Automelt EM12K	PW	>450	>350	>24	>60	>50
Automelt EH14	AW	>530	>450	>24	>70	>50
Automelt EH14	PW	>510	>420	>24	>80	>60
Automelt EA2	AW	>510	>420	>24	>50	>40
Automelt EA3	AW	>550	>470	>20	>40	>30
Automelt EA3	PW	>510	>420	>22	>50	>30

AW - As Welded; PW - After Post Weld Heat Treatment of 620°C for 1 hour

Typical Applications:

Mainly used for multi-pass welding of boilers and pressure vessels, with steel grades including IS 2002 Gr2B, ASTM A516 Gr. 60/70, etc.

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