

# AUTOMELT H25

## Classifications:

EN 760 SA CS 3 97 C Cr Mo DC

DIN 3252 B CS 3 97 DC

## Characteristics:

Automelt H25 is agglomerated submerged arc welding Calcium-Silicate type active flux for hard surfacing applications. As it is an alloying type active flux, recommended to be used with Automelt EL8 type wire. It produces weld with smooth & shiny bead appearance with very easy slag removal.

## Flux Analysis:

Basicity index No.	0.7	Grain Size (mm)	0.25-2.00
Wall Neutrality No.	45	Current/polarity	DC(+)/AC~800A max.
Flux Analysis	SiO <sub>2</sub> +TiO <sub>2</sub> -45%; CaO+MgO~20% Al <sub>2</sub> O <sub>3</sub> +MnO~15%; CaF <sub>2</sub> ~20%		
Redrying & Baking	250° C for one hour before use		

## All Weld Metal Chemistry, wt% : (Typical):

With AWL Wire	C	Mn	Si	Cr	Mo
Automelt EL8	0.12	0.90	0.65	2.10	0.15

## All weld mechanical properties:

With AWL wire	Condition	Hardness, BHN (3 layer weld pad)
Automelt EL8	AW	240-260

AW As Welded

## Typical Applications:

For surfacing of tractor rollers, truck links, crane track wheels, etc. All properties are achieved with above Wire-Flux combination. Do not change the wire.

## Packing Data

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



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