

AUTOMELT H35

Classifications:

EN 760 SA CS 3 97 C Cr Mo DC

DIN 3252 B CS 3 97 DC

Characteristics:

Automelt H35 is an agglomerated Calcium-Silicate type active alloying SAW flux for hard surfacing applications. It is also an alloying flux and thus recommended to be used only with Automelt EL8 wire. It produces crack resistant weld deposit with smooth & shiny bead appearance. The slag removal is very easy.

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 ₂ +TiO ₂ ~60%; CaO+MgO~20% Al ₂ O ₃ +MnO~15%; CaF ₂ ~05%		
Redrying & Baking	250° C for one hour before use		

All Weld Metal Chemistry, wt% :

With AWL Wire	C	Mn	Si	Cr	Mo
Automelt EL8	0.20	1.00	0.60	3.50	0.35

All weld mechanical properties:

With AWL wire	Condition	Hardness, BHN (3 layer weld pad)
Automelt EL8	AW	340-360

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. Please 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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