

AUTOMELT H45

Classifications:

EN 760 SA CS 3 97 C Cr Mo DC

DIN 3252 B CS 3 97 DC

Characteristics:

Automelt H45 is agglomerated Calcium-Silicate type active alloying SAW flux for hard surfacing applications recommended to be used only with Automelt EL8 type wire. It produces crack resistant 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 ₂ +TiO ₂ ~50%; CaO+MgO~25% Al ₂ O ₃ +MnO~20%; CaF ₂ ~05%		
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	0.20	1.20	0.80	4.35	0.70

All weld mechanical properties:

With AWL wire	Condition	Hardness, BHN (2 layer weld pad)
Automelt EL8	AW	420-460

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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