

AUTOMELT H55

Classifications:

EN 760 SA CS 3 97 C Cr Mo DC

DIN 3252 B CS 3 97 DC

Characteristics:

Automelt H55 is agglomerated Calcium-Silicate type active alloying SAW flux used for hard surfacing applications and thus recommended to be used only with Automelt EL8 wire. It produces crack resistant welds with smooth & shiny weld bead appearance with easy slag detachability.

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	0.25	1.20	0.90	5.20	1.20

All weld mechanical properties:

With AWL wire	Condition	Hardness, BHN (2 layer weld pad)
Automelt EL8	AW	540-560

AW As Welded

Typical Applications:

For surfacing of rolling mill rolls, cable sheaves, dredge ladder rolls, shear blades, etc. All properties are achieved with above Wire-Flux combination. Please do not change the wire for the best result.

Packing Data

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



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