

AUTOMELT S11

AWS Classifications:

EN 760 SA FB 2 74 Cr DC

DIN 32522 B FB 5 7484 DC 8 K

Characteristics:

Automelt S11 is an Aluminate-Fluoride basic agglomerated flux for welding stainless steels by SAW process. It is particularly an ideal stainless steel flux for fillet welding. Behavior to carbon in weld is strictly neutral, therefore can be used for extra low carbon grade stainless steels. It contains Cr-bearing compounds, thus the loss of Cr is low due to the chromium burn-off compensating characteristics. After welding it offers smooth and finely rippled X-ray quality weld with easy slag detachability.

Flux Analysis:

Basicity index No.	-1.8	Grain Size (mm)	0.25-2.00
Wall Neutrality No.	05	Current/polarity	DC(+)/AC-800A max.
Flux Analysis	SiO ₂ +TiO ₂ ~30%; CaO+MgO~20%; Al ₂ O ₃ +MnO~20%; CaF ₂ ~20%		
Redrying & Baking	300-350° C for one hour before use		

All Weld Metal Chemistry, wt% (Typical):

AWL Wires	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb
	max						max	max	max	max
Subinox 308L	0.03	19.5-22.0	9.0-11.0	0.75 max	1.0-2.5	0.30-0.65	0.03	0.03	0.75	-
Subinox 316L	0.03	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	0.75	-
Subinox 347	0.08	19.0-21.5	9.0-11.0	0.75 max	1.0-2.5	0.30-0.65	0.03	0.03	0.75	1xC-1.0%
Subinox 318	0.08	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	0.75	8xC-1.0%
Subinox 309L	0.03	23.0-25.0	12.0-14.0	0.75 max	1.0-2.5	0.30-0.65	0.03	0.03	0.75	-

All Weld Metal Mechanical Properties:

With wires	Condition	UTS	E%	CVN Impact
		Mpa	(1=4xd)	°C
				J
Subinox 308L	AW	520min	35 min	+20
Subinox 316L	AW	490min	30 min	+20
Subinox 347	AW	520min	30 min	+20
Subinox 318	AW	550min	25 min	+20
Subinox 309L	AW	520min	30 min	+20

AW As Welded

If the parameters varied markedly then the values are subject to change.

Typical Applications:

Recommended for high alloy austenitic stainless steel welding.

Packing Data

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



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