

# AUTOMELT S79

## Classifications:

EN 760 AC8MHP5

DIN 32522 B FB 6 57559

## Characteristics:

Automelt S79 is a specially designed agglomerated Fluoride-Basic stainless steel welding flux for 9% Ni steels using Subinox NiCrMo3 wire electrodes. The weld metal entirely meets the strength requirements of the base metal, so that full advantage can be taken of the design stress values of SA353 C11 or SA553 C11 steels. Automelt S79 has no Chromium compensation; however there is no loss of chromium. Automelt S79 is strictly neutral as regard to pick up or burn off of Silicon and Manganese. It gives an extra low hydrogen weld deposit and may be used with AC and DC (+).

## Flux Analysis:

Basicity index No.	-2.7	Grain Size (mm)	0.25-2.00
Wall Neutrality No.	-	Current/polarity	DC(+)/AC~800A max.
Flux Analysis	SiO <sub>2</sub> +TiO <sub>2</sub> ~15%; CaO+MgO~40% Al <sub>2</sub> O <sub>3</sub> +MnO~25%; CaF <sub>2</sub> ~20%		
Redrying & Baking	300-350° C for one hour before use		

## Weld Metal Chemistry, wt% :

With AWL wire	C	Mn	Fe	Si	Cr	Cb+Ta	Mo	S	P	Cu	Ni
Subinox NiCrMo3	0.10 max	1.0 max	7.0 max	0.75 max	20.0-23.0	3.15-4.15	8.0-10.0	0.02 max	0.03 max	0.50 max	55.0 min

## All Weld Metal Mechanical Properties:

With wires	Condition	UTS	E% (l=4xd)	CVN Impact	
		MPa		°C	J
Subinox NiCrMo3	AW	760	30 min.	-196	50-55

AW As Welded

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

## Typical Applications:

ASTM class 1, SA-353 class1. For welding of 9% Nickel steels for cryogenic applications, especially LNG storage systems. Welding on stainless / heat resistant cryogenic steels and alloys for welding nickel base alloys.

## Packing Data

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



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