

AUTOMELT A61

Classifications:

With Wire	AWS 5.17/5.23	AWS 5.17M/5.23M
Automelt EL8	F7A0 - EL8	F48A2 - EL8
Automelt EM12K	F7A2/P2 - EM12K	F48A3/P3 - EM12K
Automelt EA2	F8A0 - EA2 - A4	F55A2 - EA2 - A4

Characteristics:

Automelt A61 is Manganese-silicate type of submerged arc welding flux with high current carrying capacity. It is active flux with high Si and Mn pickup. This is particularly suited for single and multi-wire welding at high speed. Due to the active nature of the flux it has high restraint cracking resistance.

Basicity	Wall Neutrality No.	Grain Size (mm)
1.0*	85	0.25-1.60

*-As per Boniszewski

Flux Analysis:

SiO ₂ + TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂
35 %	15 %	40 %	5 %

All Weld Metal Chemistry, wt% (Typical):

With wire	C	Mn	Si	S	P	Mo
Automelt EL8	0.06	1.3	0.7	<0.03	<0.03	-
Automelt EM12K	0.06	1.5	0.9	<0.03	<0.03	-
Automelt EA2	0.06	1.5	0.7	<0.03	<0.03	0.45

All weld metal properties:

With wire	Condition	UTS Mpa	YS MPa	% Elongation (L=4d)	CVN Impact (J)		
					0 °C	-20 °C	-30 °C
Automelt EL8	AW	>480	>400	>24	>50	>30	--
Automelt EM12K	AW	>510	>420	>24	--	>50	>30
Automelt EM12K	PW	>480	>400	>24	--	--	>40
Automelt EA2	AW	>550	>460	>22	>50	>30	--

AW - As Welded; PW - After Post weld heat treatment of 620 °C for 1 hour

Typical Applications:

Best suited for High-Speed butt-welding applications. Welding speeds of 2m/min are possible. Particularly suited for twin wire, tandem and multi wire welding at relatively high speed: Pipe Mills - spiral and longitudinal welding

Packing Data

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



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