

BÖHLER FOX EV PIPE

Basic coated stick electrode

Main benefit:
Basic coated stick electrode for vertical up welding of pipelines.



Product features	Product benefits	User benefits
» Faster melting	» Larger welding length	» Safe welding time and money compared to standard AWS E7018 stick electrodes
» Good for AC current	» Welding on different power sources	» Also suitable for steel construction
» Suited for sour-gas	» HIC – Test acc. to NACE TM-02-84 passed	» This electrode can be used also for sour-gas applications

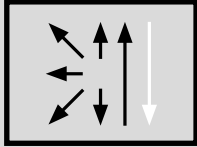
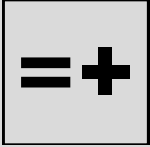


Typical applications

- » Pipeline
- » Steel construction

FOX EV Pipe was designed and optimized for vertical up welding on large pipelines. This electrode is in principal similar to a standard AWS E7018 rod. The focus of the development was a faster travel speed with the result that this electrode ensures a clear shorter welding time. Root pass welding is possible on DC (-), over a wall thickness of 8 mm diam. 3,2 mm is also suited for root pass welding. In addition welding also on AC current enlarges the field of application.

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Classifications		Operating data	
EN ISO 2560-A	AWS A5.5 / SFA-5.5	Welding positions	Polarity
E 42 4 B 1 2	E7016-1		 DC (-) for root pass

Typical chemical composition, all weld metal, wt. %		
C	Si	Mn
0.06	0.6	0.9

Mechanical properties, all weld metal (single values typical)						
Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation A ($L_0=5d_0$) %	CVN Impact toughness ISO-V KV J		
				20 °C	-40 °C	-45 °C
As welded	470 (≥ 420)	560 (500 - 640)	29 (≥ 20)	170	100 (≥ 47)	65 (≥ 27)

Steels to be welded	
EN	ASTM
P235GH, P265GH, P295GH, P235T1, P275T1, P235G2TH, P255G1TH, (S255N-S420N ^{*1}), S255NL1-S420NL1, L290NB-L360NB, L290MB-L415MB, (L450MB-L555MB ^{*2})	API Spec. 5L: A, B, X 42, X46, X52, X56, X60, (X65-X80 ^{*2}) ASTM: A53 Gr. A-B, A106 Gr. A-C, A179, A192, A210 Gr. A-1
^{*1}) stress relieved up to S380N / S380NL1	
^{*2}) only for root pass	

Approvals
TÜV (07620.), DB (10.014.77), CE, NAKS, GAZPROM

Metal tin Packaging	Dry System Vakuum Packaging
 <p>Weight: ~ 4.2 kg</p> <p>Diameter: 2.0 x 300 mm 2.5 x 300 mm 3.2 x 350 mm 4.0 x 350 mm</p>	 <p>Weight: DrySys 20: ~1.2 kg DrySys 30: ~ 2.1 kg</p> <p>Diameter: 2.0 x 300 mm 2.5 x 300 mm 3.2 x 350 mm 4.0 x 350 mm</p>