

BÖHLER FOX EV 47

Unalloyed, basic coated stick electrode

Main benefit:

Basic coated stick electrode for unalloyed steels with a yield strength up to 380 MPa.



Product features	Product benefits	User benefits
» Basic coated	» High impact values	» High-quality welds, suitable also for very low service temperatures
» Low hydrogen content » < 4 ml/mg all weld metal	» Avoids hydrogen induced cracks	» Safe joints, no repair welds necessary
» Very ductile weld metal, aging resistant	» Good repair characteristics also for heavy wall thicknesses	» Suitable for welding of bigger, stiff parts



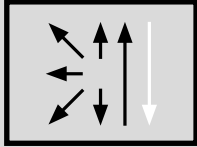
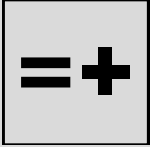
Typical applications

- » Steel construction
- » Ship building
- » Construction of storage tanks

BÖHLER FOX EV 47 is a basic coated stick electrode with lower strength but with a very ductile and tough weld metal. The very low hydrogen content in the weld metal supports this characteristic and avoids hydrogen-induced cracks. In addition, the moisture resistant coating is another supporting feature. This feature makes it possible to use the electrode for a longer time after re-backing.

There is a broad range of application everywhere in steel constructions where a tough joining is required especially for bigger, stiff parts with big wall cross sections.

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Classifications		Operating data	
EN ISO 2560-A	AWS A5.1 / SFA-5.1	Welding positions	Polarity
E 38 4 B 4 2 H5	E7016-1 H4R		

Typical chemical composition, all weld metal, wt. %		
C	Si	Mn
0.06	0.3	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
As welded	440 (≥ 380)	530 (470 – 600)	27 (≥ 22)	200	100 (≥ 47)

Steels to be welded	
EN	ASTM
Steels up to a yield strength of 380 MPa (52 ksi) S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S355N, S275M-S355M, P235GH-P355GH, P355N, P275NL1-P355NL1, P215NL, P265NL, P285NH-P355NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, GE200-GE240, Ship-building steels: A, B, D, E, A 32-E 36	ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 678 Gr. A, B; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56

Approvals
TÜV (01098), DB (10.014.09), ABS, BV, DNV, LR, RMR, RINA, CE

Carton Packaging	
	Weight: ~ 4,1 kg Diameter: 2.5 x 250 mm 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm 4.0 x 450 mm 5.0 x 450 mm 6.0 x 450 mm