

BÖHLER FOX EV 60

Low-alloyed basic coated stick electrode

Main benefit:

Basic coated stick electrode for high strength steels with 1 % Ni particularly high ductility at low temperatures.



Product features	Product benefits	User benefits
<ul style="list-style-type: none"> » Ni content 0.9 % » High ductility at - 60 °C 	<ul style="list-style-type: none"> » Suited for sour gas applications » Big service temperature window from -60 °C up to 350 °C 	<ul style="list-style-type: none"> » Various applications in various high demanding industries
<ul style="list-style-type: none"> » Moisture resistant coating 	<ul style="list-style-type: none"> » Very low hydrogen content in the all weld metal » No risk for hydrogen induced cracks 	<ul style="list-style-type: none"> » Electrodes can be used up to 9h after opening a Dry System packaging or a hermetical tin without re-drying
<ul style="list-style-type: none"> » CTOD approved at -40 °C 	<ul style="list-style-type: none"> » Approved for welding of armoured plates 	<ul style="list-style-type: none"> » Suitable also for special requirements like CTOD or SSC tests
<ul style="list-style-type: none"> » Available in Dry System vacuum packs 	<ul style="list-style-type: none"> » Welding directly out of the package without re-drying 	<ul style="list-style-type: none"> » Less time for preparation, always safe packed, fresh stick electrodes



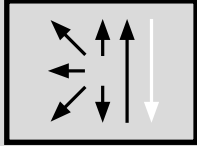
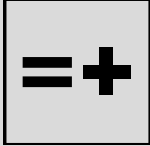
Typical applications

- » Offshore industry
- » Steel constructions
- » Armored plates

The recipe of the BÖHLER FOX EV 60 stick electrode was designed as a typical 1% Ni filler metal. That means optimized for very high toughness at low temperatures. The Ni content is limited to a maximum of 1%.

As a result, this electrode can be used in many different ways. The hydrogen content, which is reduced to 4 ml/100g weld metal, as with all electrodes of the EV series, a moisture-resistant coating and the possible Dry System vacuum packaging, make this electrode a special product.

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Classifications		Operating data	
EN ISO 2560-A	AWS A5.5 / SFA-5.5	Welding positions	Polarity
E 46 6 1Ni B 4 2 H5	E8018-C3 H4 R		

Typical analysis of all weld metal, wt. %			
C	Si	Mn	Ni
0.07	0.4	1.15	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	-60 °C
Untreated, as welded	510 (≥ 460)	600 (550 – 680)	29 (≥ 20)	200	120 (≥ 47)

Steels to be welded	
EN	ASTM
Constructional steels, pipe- and vessel steels, cryogenic fine-grained steels and special grades S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2-P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB alform plate 460M; durostat 400, 450, 500, durostat B2	ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q

Approvals
TÜV (01524), DNV, RMR, VG 95132, ABS, CE

Carton Packaging	Dry System Vacuum Packaging
 <p>Weight: ~ 4.1 kg</p> <p>Diameter: 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</p>	 <p>Weight: DrySys 20: ~1.2 kg DrySys 30: ~ 2.1 kg</p> <p>Diameter: 2.5 x 350 mm 3.2 x 350 mm 4.0 x 450 mm 5.0 x 450 mm</p>