

BÖHLER FOX NiCuCr

Ni-Cu-Cr-alloyed, basic coated stick electrode

Main benefit:
Stick electrode particular for welding of weather-resistant steels.



Product features	Product benefits	User benefits
» Ni-Cu-Cr alloyed electrode	» Adjusted to the chemical composition of weather-resistant steels	» Optimized welding of similar weather-resistant steels
» Very low hydrogen content	» Crack resistant weld seams	» No post-weld repair work
» Moisture resistant coating	» Very low moisture absorption	» Electrodes could be welded much longer after re-backing

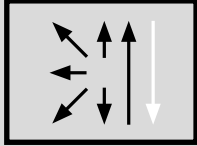
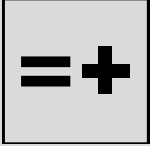


Typical applications

- » Steel construction – weather resistant steel beams
- » Structural-facing sector – weather resistant steel facing
- » Sculptures – the rusty color of the steel allows several artwork

The speciality of BÖHLER FOX NiCuCr is the field of application. This electrode was developed to weld special, weather-resistant steels like Patinax® or Corton. The chemical composition of the electrode results in a very similar composition as the base material after welding. Thus, the weld seam builds the same corrosion resistant rusty coating as the base material. Therefore, also this rusty color of the seam is identical with the base material.

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Classifications		Operating data	
EN ISO 2560-A	AWS AWS A5.5 / SFA-5.5	Welding positions	Polarity
E 46 4 Z1NiCrCu B 4 2 H5	E8018-W2 H4 R		

Typical chemical composition, all weld metal, wt. %					
C	Si	Mn	Cr	Ni	Cu
0.05	0.4	0.7	0.6	0.6	0.45

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	520 (≥ 460)	570 (530 – 680)	27 (≥ 20)	200	130 (≥ 47)

Steels to be welded	
EN	ASTM
Weather resistant steels S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W ASTM A 588 Gr. A, B, C, K; A 618 Gr. II; 709 Gr. C	ASTM A 588 Gr. A, B, C, K; A 618 Gr. II; 709 Gr. C

Approvals
RMR, CE

Carton Packaging	Dry System Vakuum Packaging
 <p>Weight: ~ 4.2 kg</p> <p>Diameter: 2.5 x 350 mm 3.2 x 350 mm 4.0 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</p>