

BÖHLER FOX EV 40

Unalloyed, basic coated stick electrode

Key feature

Basic coated stick electrode for unalloyed steels with very low yield strength up to 355 MPa.



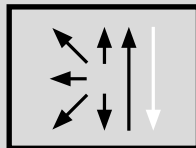
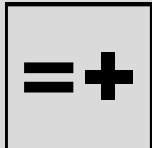
Product features	Product benefits	User benefits
» Basic coated	» High impact values	» High-quality welds, suitable also for very low service temperatures
» Low hydrogen content < 4 ml/mg all weld metal	» Avoids hydrogen induced cracks	» Safe joints, no repair welds necessary
» very ductile weld metal with high elongation	» No hardness peaks due to very “flexible” weld metal	» Join welding parts with a very fast heat flow, e.g. hot tapping



Typical application

- » Hot Tapping (welding of flanges and tee-pipes in operation)
- » Hot Tapping of storage pressure vessels
- » Steel construction
- » Root pass welding whenever high toughness and a low strength and/or low hardness is required

BÖHLER FOX EV 40


Classifications		Operating data	
EN ISO 2560-A	AWS AWS A5.5 / SFA-5.5	Welding positions	Polarity
E 46 8 2Ni B 4 2 H5	E8018-C1 H4 R		

Typical analysis of all weld metal, wt. %				
	C	Si	Mn	Ni
	0.04	0.3	0.8	2.4

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	-80 °C
	Untreated, As welded	490 (≥ 460)	570 (530 – 680)	30 (≥ 20)	180	110 (≥ 47)

Steels to be welded	
EN	ASTM
KCryogenic constructional steels and Ni-steels, cryogenic steels for ship building 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2	ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 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

Approvals
TÜV (00147), DB (10.014.16), ABS, WIWEB, DNV GL, LR, RINA, CE

Carton Packaging	Dry System Vacuum Packaging
 <p>Weight: ~ 4.2 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>	 <p>Diameter: 2.5 x 350 mm 3.2 x 350 mm 4.0 x 450 mm 5.0 x 450 mm</p>