



# BÖHLER FOX EV PIPE

## Basic coated stick electrode

Key feature

Basic coated stick electrode for vertical up welding of pipelines.

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



### Typical applications

- » Pipeline
- » Steel construction

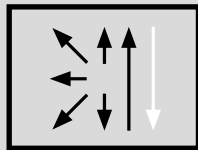
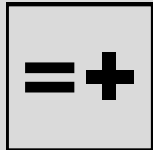
FOX EV Pipe was designed and optimized for vertical up welding on large pipelines.

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 <sub>p0.2%</sub> MPa	Tensile strength R <sub>m</sub> MPa	Elongation A (L <sub>0</sub> =5d <sub>0</sub> ) %	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 <sup>*1</sup> ), S255NL1-S420NL1, L290NB-L360NB, L290MB-L415MB, (L450MB-L555MB <sup>*2</sup> )	API Spec. 5L: A, B, X 42, X46, X52, X56, X60, (X65-X80 <sup>*2</sup> ) ASTM: A53 Gr. A-B, A106 Gr. A-C, A179, A192, A210 Gr. A-1
<sup>*1</sup> ) stress relieved up to S380N / S380NL1	
<sup>*2</sup> ) only for root pass	

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

Carton Packaging	Dry System Vakuum Packaging
 <p>Weight: ~ 4.2 kg</p> <p>Diameter: 2.0 x 300 mm 3.2 x 350 mm 4.0 x 450 mm</p>	 <p>Diameter: 2.0 x 300 mm 3.2 x 350 mm 4.0 x 450 mm</p>