

BÖHLER FOX P 22 / BÖHLER FOX P 22 (LC)

Basic coated stick electrodes



Key feature

Stick electrodes for welding of creep resistant steels with 2,25 % Cr and 1 % Mo.

Product features	Product benefits	User benefits
» Synthetic coating	» Easy to handle even at difficult conditions	» Perfect for repair welding jobs
» Optimized slag concept	» Avoids uncontrolled flow of the slag when welding in 6G position (45° inclined tube)	» Safer welding and less post weld work
» Two variants: » FOX P 22 » FOX P 22 (LC)	» Application optimized C = 0,06 for higher creep resistance C ≤ 0,04 for lower hardness thus for aged material	» Selection of the best electrode according to the repair requirements



Typical applications

- » Repair welding jobs in thermal power plants

Both variants have been developed for repair welding jobs in thermal power plants, e.g. partly changing of tubes. The coating concept of the electrodes is synthetic, that means the alloying content is in the coating, in order to optimize the welding behavior and the slag control during welding.

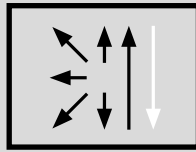
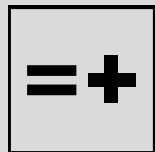
This is a very important point for such jobs, because you are not able to move the welding parts, which causes often welding in position and/or on inclined tubes.

BÖHLER FOX P 22 / P 22 (LC) – the easy welding solution for the welder!

The difference of the two types is the carbon content. The LC – for Low Carbon – type has a C-content of max. 0,04 %. This low content leads to less or hardness peaks and makes it much easier to weld a safe joint with enough ductility also for aged materials.

On the other hand, the standard type with a C-content of ca. 0,06 % leads to a higher creep resistance.

The perfect choice depending on your requirements.

Classifications BÖHLER FOX P 22		Operating data	
EN ISO 3580-A	AWS A5.5 / SFA-5.5	Welding positions	Polarity
E CrMo2 B 4 2 H5	E9018-B3		
Classifications BÖHLER FOX P 22 (LC)			
EN ISO 3580-A	AWS A5.5 / SFA-5.5		
E CrMo2L B 4 2 H5	E8018-B3L		

Typical chemical composition, all weld metal, wt. %					
	C	Si	Mn	Cr	Mo
BÖHLER FOX P 22	0.06	0.3	0.7	2.2	1.0
BÖHLER FOX P 22 (LC)	≤ 0.04	0.3	0.6	2.2	1.0

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	
BÖHLER FOX P 22	As welded	≥ 530	≥ 620	≥ 22	120	≥ 47
BÖHLER FOX P 22 (LC)	As welded	≥ 460	≥ 550	≥ 22	120	≥ 47

Steels to be welded	
EN	ASTM
10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 15CrMoV5-10;	ASTM A335 Gr. P22, A217 Gr. WC9

Approvals
CE

Dry System Vacuum Packaging	
	Diameter: 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm