

Revisionsnummer: 2

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5 / SFA-5.5	AWS A5.5M
E 50 4 1Ni B 1 2 H5	E5516-G A H5	E8016-G H4R	E5516-G H4R

Characteristics and typical fields of application

Basic coated electrode excellent suited for positional welding for filler and cover passes for pipes, tubes and plates. Good impact properties down to -40°C , low hydrogen content ($\text{HD} < 4 \text{ ml}/100 \text{ g}$), as well as packaging in hermetically sealed tins are further features for the user.

Base materials

EN: S235J2G3 - S355J2G3, L210NB - L450NB, L210MB - L450MB, P235GH - P295GH, E295, E335, S355J2G3, C35-C45, P310GH, S380N - S460N, P380NH-P460NH, S380NL - S460NL, S380NL1 - S460NL2, GE260-GE300

API Spec. 5 L: X 42, X46, X 52, X 56, X 60, X 65

ASTM A516 Gr. 65, A572 Gr. 55, 60, 65, A633 Gr. E, A612, A618 Gr. I, A537 Gr. 1-3

Typical analysis

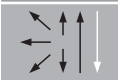
	C	Si	Mn	Ni
wt.-%	0.07	0.6	1.2	0.9

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J				
	MPa	MPa	%	20°C	0°C	-20°C	-40°C	-45°C
u	540 (≥ 500)	620 (560 – 720)	26 (≥ 18)	170	150	140	110 (≥ 47)	60

u untreated, as welded

Operating data

	Polarity	DC (+)	Dimension mm	Current A	
	Electrode identification	FOX EV 60 PIPE 8016-G E 50 4	1 Ni B	2.5 × 300	40 – 90
				3.2 × 350	60 – 130
				4.0 × 350	110 – 180
				5.0 × 450	180 – 230

Preheat and interpass temperatures as required by the base material. The electrodes are ready for use straight from the tins.

Approvals

BV, CE