

Classifications

AWS A5.5 / SFA-5.5	AWS A5.5M	EN ISO 18275-A	EN ISO 18275-B
E9018-G H4 R	E6218-G H4 R	E 55 5 Z2Ni B 4 5 H5	E 6245-G A U H4
E9045-G H4 R	E6245-G H4 R		

Characteristics and typical fields of application

Basic coated electrode for vertical-down welds of large diameter pipelines and for structural work. Suitable for filler and cover pass welding in pipeline construction. Deposit is extremely crack resistant, and features high toughness and a very low hydrogen content. Special design and development work has enabled this electrode to provide exceptional striking characteristics and the avoidance of start porosity. Due to this and the good welding characteristics this special basic electrode offers easy handling even under field conditions. Deposition rate is 80 – 100% higher than for vertical up welding.

Base materials

L485MB, L555MB
API Spec. 5 L: X70, X80

Typical analysis

	C	Si	Mn	Ni
wt.-%	0.05	0.3	1.2	2.2

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				
	ksi	ksi	%	68°F	-4°F	-22°F	-40°F	-58°F
u	84 (≥ 80)	94 (90 – 113)	27 (≥ 18)	125	96	81	66	52 (≥ 35)

u untreated, as welded

Operating data

	Polarity	DC (+)	Dimension inch	Current A
	Electrode identification	FOX BVD 90 9045-G/9018-G E 55 5 Z2Ni B	3/32" × 14"	80 - 110
	Redrying	if necessary: 525 – 625°F / min. 2 h	1/8" × 14"	110 – 160
			5/32" × 14"	180 – 210
			3/16 × 14"	200 – 240

Recommended interpass temperature < 200 °F note: should be "less than"

Approvals

TÜV (03402.)