

Classifications

AWS A5.1 / SFA-5.1	AWS A5.1M	EN ISO 2560-A	EN ISO 2560-B
E7016-1	E4916-1	E 42 4 B 1 2	E4916-1 A

Characteristics and typical fields of application

Basic coated electrode, excellent suited for positional welding of root passes using DC- polarity as well as for fill and cap passes of pipes, tubes and plates on DC+ polarity and AC. It is user friendly and provides good gap bridging ability together with easy slag removal to ensure minimum grinding. Good weld metal toughness down to -50°F. BÖHLER FOX EV PIPE offers considerable time savings against AWS E7018 type electrodes when welding root passes due to increased travel speeds. Also the use of 1/8" diameter is possible for root passes in case of wall thicknesses of 5/16 in and more. BÖHLER FOX EV PIPE can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are also available.

Base materials

P235GH, P265GH, P295GH, P235T1, P275T1, P235G2TH, P255G1TH, (S255N-S420N *1)

S255NL1-S420NL1, L290NB-L360NB, L290MB-L415MB, (L450MB-L555MB *2)

API Spec. 5L: A, B, X 42, X46, X52, X56, X60, (X65-X80 *2)

ASTM: A53 Gr. A-B, A106 Gr. A-C, A179, A192, A210 Gr. A-1

*1) stress relieved up to S380N / S380NL1

*2) only for root pass

Typical analysis

	C	Si	Mn
wt.-%	0.06	0.60	0.9

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

Condition	Yield strength R_p	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV ft-lbs			
	ksi	ksi	%	68°F	0°F	-40°F	-50°F
u	68 (≥ 61)	81 (73 – 93)	29 (≥ 20)	125	89	74 (≥ 35)	48 (≥ 20)

u untreated, as welded

Operating data

	Polarity	DC+ (DC- for root pass)	Dimension	Current A
	Electrode identification	FOX EV PIPE 7016-1 E 42 4 B	5/64" × 12"	30 – 60
			3/32" × 12"	40 – 90
			1/8" × 14"	60 – 130
			5/32" × 14"	110 – 180

Approvals

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