BÖHLER FOX BVD 100

Basic vertical down stick elekctrode, low-alloyed, pipeline welding

Classifications

EN ISO 18275-A	AWS A5.5 / SFA-5.5	AWS A5.5M
E 62 5 Z2Ni B 4 5	E10018-G	E6918-G
	E10045-P2 (mod.)	E6945-P2 (mod.)

Characteristics and typical fields of application

Basic coated electrodes 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. 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

L555MB
API Spec. 5 L: X80

Typical analysis

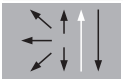
	C	Si	Mn	Ni
wt.-%	0.07	0.4	1.2	2.3

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	-20°C	-30°C	-50°C
u	640 (≥ 620)	720 (690 – 890)	24 (≥ 18)	150	120	105	60 (≥ 47)

u untreated, as welded

Operating data



Polarity	DC (+)
Electrode identification	FOX BVD 100 10018-G E 62 5 Z2Ni B
Redrying	if necessary: 300 – 350 °C / min. 2 h

Dimension mm	Current A
3.2 × 350	100 – 160
4.0 × 350	180 – 210
4.5 × 350	200 – 240

Recommended interpass temperature > 100ºC

Approvals

TÜV (06333.), CE