

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 42 3 B 3 2	E 4916 AU	E7016	E4916

Characteristics and typical fields of application

BÖHLER FOX EV 50 Pipe is a basic covered electrode especially developed for pipeline construction. Very clean weld metal with high toughness properties. Especially intended for welding of pipes and for pipe root welds. Sound, well penetrated root welds are achieved in all position without any backup welding. HIC and HSCC tested.

Base materials

L245MB-L415MB,
API 5L: -X60 (X70 for root pass only)


Typical analysis

	C	Si	Mn
wt.-%	0.06	0.55	1.0

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

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-30°C
u	460 (≥ 420)	560 (≥ 510)	30 (≥ 25)	145 (120)	50 (≥ 47)

Operating data

	Polarity	AC/DC (+); for root pass DC(-) possible	Dimension mm	Current A
	Electrode identification	FOX EV 50 Pipe / E 42 3 B / E7016	2.5 x 350	60 - 110
	Redrying	250-350°C/2h	3.2 x 350	80 - 130
			4.0 x 350	120 - 180

Approvals

CE