

EN ISO 18275-A: E 55 6 1NiMo B 4 2 H5
 AWS A5.5: E8018-GH4R
 E8018-D1H4R (mod.)
 AWS A5.5M: E5518-GH4R
 E5518-D1H4R (mod.)

BÖHLER FOX EV 65

**SMAW basic electrode, low-alloyed,
high strength**

Description

Basic electrode with high ductility and crack resistance, for high- strength fine- grained steels. Ductile down to -60 °C. Resistant to ageing.

Easy to handle in all positions, except vertical- down.

Very low hydrogen content (acc. to AWS condition HD <4 ml/100 g weld metal).

Typical Composition of All-weld Metal

	C	Si	Mn	Ni	Mo
wt-%	0.06	0.3	1.2	0.8	0.35

Mechanical Properties of All-weld Metal

	u		s	
yield strength R_e N/mm ² (MPa):	600	(≥550)	580	(≥530)
tensile strength R_m N/mm ² (MPa):	650	(630-750)	630	(620-730)
elongation A ($L_0=5d_0$) %:	25	(≥20)	25	(≥20)
impact work ISO-V KV J				
+20°C:	180	(≥130)	160	(≥120)
-60°C:	80	(≥47)		

u untreated, as-welded

s stress relieved 580°C/2h/furnace down to 300°C/air

Operating Data



re-drying if necessary:

300-350°C, min. 2 h

electrode identification:

FOX EV 65 8018-G E 55 6 1NiMo B

ø mm	L mm	amps A
2.5	350	80-100
3.2	350	100-140
4.0	450	140-180

=+

Preheating and interpass temperature, as well as post welds heat treatment as required by the base metal.

Base Materials

Constructional steels, pipe- and vessel steels, cryogenic fine-grained steels and special grades

E295 - E360, 20MnMoNi5-5, 22NiMoCr4-7, P355NL1-P460NL1, P355NL2 - P460NL2, S380N - S500N, S355NH - S460NH, S380NL - S500NL, S380NL1 - S500NL1, 15NiCuMoNb5S (WB 36), 20MnMoNi5-5, 17MnMoV6-4 (WB 35), 22NiMoCr4-7, EN 10208-2: L415MB, L450MB, L485MB

ASTM A302 Gr. A-D; A517 Gr. A, B, C, E, F, H, J, K, M, P; A225 Gr. C; A572 Gr. 65

API Spec. 5 L: X60, X65, X70

Approvals and Certificates

TÜV-D (1802.), SEPPOZ, CE, NAKS (Ø3,2-4,0 mm)