

EN ISO 2560-A: E 46 6 1Ni B 42 H5
 EN ISO 2560-B: E 55 18-N2 A U H5
 AWS A5.5: E8018-C3H4R
 AWS A5.5M: E5518-C3H4R

BÖHLER FOX EV 60

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

Description

Basic Ni- alloyed electrode with excellent mechanical properties, particularly high toughness and crack resistance. For higher strength fine- grained constructional steels.

Suitable for service temperatures at – 60°C to +350°C. Very good impact strength in aged condition. Metal recovery about 115%. Easily weldable in all positions except vertical-down.

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

Typical Composition of All-weld Metal

	C	Si	Mn	Ni
wt-%	0.07	0.4	1.15	0.9

Mechanical Properties of All-weld Metal

	u		s	
yield strength R_e N/mm ² (MPa):	510	(≥470)	480	(≥460)
tensile strength R_m N/mm ² (MPa):	610	(580-680)	580	(560-680)
elongation A ($L_0=5d_0$) %:	27	(≥24)	27	(≥23)
impact work ISO-V KV J				
+20°C:	180	(≥130)	160	(≥120)
-60°C:	110	(≥65)		

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:

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ø mm	L mm	amps A
2.5	350	80-100
3.2	350	110-140
4.0	450	140-180
5.0	450	190-230



Base Materials

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

E295, E335, S355J2G3, C35-C45, L210 – L450NB, L245MB – L450MB, P310GH, P355NL1-P460NL1, P355 NL2-P460NL2, S380N - S460N, P355NH-P460NH, S380NL - S460NL, S380NL1, GE260-GE300

ASTM A516 Gr. 65, A572 Gr. 55, 60, 65, A633 Gr. E, A612, A618 Gr. I, A537 Gr. 1-3.

Approvals and Certificates

TÜV-D (1524.), TÜV-A (275), DNV (3 YHH), RMR (3 YHH), Statoil, LTSS, SEPROZ, CRS (3YH5), CE