# BOHLER FOX S EV PIPE

Stick electrode, unalloyed basic

| Classifications | | |
|---|---|---|
| **AWS A5.1** | **JIS Z321** | |
| E7016 | E4316 | |

**Characteristics and field of use**

BÖHLER FOX S EV PIPE is a basic electrode suited for positional welding of root passes using both D.C. negative and D.C. positive polarity as well as for filler and cover passes of pipes, tubes and structural/plates.

**Typical analysis of all weld metal (Wt.-%)**

| C | Si | Mn | P | S | | |
|---|---|---|---|---|---|---|
| 0.08 | 0.50 | 0.5 | 0.02 | 0.02 | | |

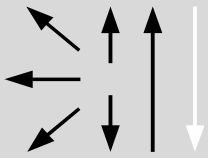
**Base materials**

S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB, X42 – X60; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52; SA 516 Gr 60, 65, 70; SA333 Gr 6.

**Mechanical properties of the weld metal**

| Tensile strength | Yield Strength | Elongation | Impact strength | |
|---|---|---|---|---|
| [MPa] | [MPa] | [%] | [-30°C] | [-40°C] |
| 560 | 490 | 30,0 | 47 | 40 J |

**Welding Position**



**Polarity**
DCEP
(DCEN for root pass)

Re-drying if necessary: 300 – 350°C, min. 2 h. Preheated and interpass temperature as required by the base material. The optimum gap width for root passes is 2-3 mm, the root face should be in the range 2-2.5 mm.

**Approval**

ABS (4Y)

**Size, Packing and Recommended welding parameters**

| Size (mm) | | Carton Pack | | Dry System | | Amperage (A) |
|---|---|---|---|---|---|---|
| Dia | Length | Kg / Pack | Kg / Box | Kg / Pack | Kg / Box | |
| 2,50 | 350 | 5.0 | 20.0 | 2.0 | 16.0 | 40- 90 |
| 3,25 | 350 | 5.0 | 20.0 | 2.0 | 16.0 | 60 - 130 |
| 4,00 | 400 / 450 | 5.0 | 20.0 | 2.0 | 16.0 | 110 -180 |

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.