EN ISO 2560-A:2010: E 50 4 B 42 H5
EN ISO 2560-B:2010: E 57 18-G A H5
AWS A5.5-06: E8018-GH4R
AWS A5.5M-06: E5518-GH4R

BÖHLER FOX EV 63

SMAW basic electrode, low-alloyed, high strength

Description

Basic electrode for carbon and low-alloy steels of higher strength with carbon contents up to 0.6 %. Also suitable for rail joint welding.
Ductile and crack resistant weld metal. Metal recovery approx. 115 %. Weldable in all positions except vertical-down.
Very low hydrogen content (according AWS condition HD ≤ 4 ml/100 g weld metal).

Typical Composition of All-weld Metal

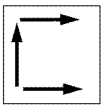
	C	Si	Mn
Wt-%	**0.08**	**0.7**	**1.7**

Mechanical Properties of All-weld Metal

(*)		u		s	
Yield strength R_e N/mm² (MPa):		**580**		**560**	(≥ 500)
Tensile strength R_m N/mm² (MPa):		**630**	(610 - 720)	**610**	(590 - 710)
Elongation A ($L_0 = 5d_0$) %:		**26**	22)	**26**	(≥ 24)
Impact work ISO-V KV J	+ 20 °C:	**170**		**130**	(≥ 100)
	- 40 °C:	**90**	(≥ 47)		

(*) *u untreated, as-welded*
s stress relieved 580 °C/2 h/furnace down to 300 °C/air

Operating Data



re-drying if necessary:
300 - 350 °C, min. 2 h
electrode identifikation:
FOX EV 63 8018-G E 50 4 B

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

Base Materials

constructional steels, pipe steels, rail steels

S355J2G3, E295 - E360, C35 - C60, S355N - S500N, P315NH - P500NH, GE200 - GE300, R0800

ASTM A225 Gr. C; A517 Gr. A, B, C, E, F, H, J, K, M, P

Approvals and Certificates

TÜV-D (0730.), DB (10.014.07 / 81.014.01), ÖBB, TÜV-A (X), RMR (3 YHH), SEPROZ, CE

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