

Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 55 4 ZMn2NiMo B 1 2 H5	E9016-GH4R	E6216-GH4R

Characteristics and typical fields of application

Basic covered electrode for high strength steels. It is excellent suited for positional welding of filler and cover passes of pipes, tubes and plates on D.C. positive polarity.

It is user friendly and provides a good gap bridging ability together with easy slag removal to ensure minimum grinding.

Good impact properties down to -40 °C, low hydrogen content (HD < 5 ml/100 g).

Base materials

L450MB, L485MB, L555MB
API Spec. 5 L: X65, X70, X80

Typical analysis of all-weld metal

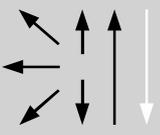
	C	Si	Mn	Ni	Mo
wt.-%	0.06	0.5	1.7	2.2	0.3

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

Condition	Yield strength R _{eH}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
				+20 °C	-20 °C	-40 °C	-45 °C
u	630 (≥ 550)	700 (620 – 780)	20 (≥ 18)	140	90	70 (≥ 47)	60

u untreated, as welded

Operating data

	Polarity: DC (+)	Redrying: 300 – 350 °C, min. 2 h	Electrode identification: FOX EV 70 PIPE 9016-G	ø mm	L mm	Amps A
				2.5	300	40 – 90
				3.2	350	60 – 130
4.0	350	110 – 180				

Preheat and interpass temperature as required by the base material. The electrodes are ready for use straight from the hermetically sealed tins.

Approvals

TÜV (12809.), CE