BÖHLER FOX BVD 110

Basic stick electrode for vertical-down welding, pipe welding

Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 69 3 Mn2NiMo B 4 5	E11018-G	E7618-G

Characteristics and typical fields of application

Basic electrodes for vertical-down welds of large diameter pipelines and for structural work. Suitable for filler and cover pass welding in pipeline construction. Deposit is extremely crack resistant, and features high toughness and a very low hydrogen content. Deposition rate is 80 – 100 % higher than for vertical up welding. This stick electrode is optimised for best striking properties and for avoiding start porosity in the cap layer. With its excellent welding properties the electrode offers easy handling also under difficult conditions.

Base materials

L690[1)]
API Spec. 5 L:X100[1)]

[1)] not standardised yet

Typical analysis of all-weld metal (wt.-%)

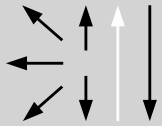
	C	Si	Mn	Ni	Mo
wt-%	0.07	0.4	1.5	2.2	0.4

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	–20 °C	–40 °C
u	**720** (≥ 690)	**810** (760-960)	**20** (≥ 17)	**90**	**70**	**50** (≥ 47)

u untreated, as welded

Operating data



Polarity:	Redrying if necessary:	Electrode identification:	ø (mm)	L mm	Amps A
DC (+)	300 – 350 °C / min. 2 h	FOX BVD 110 11018-G E 69 3 Mn2NiMo B	4.0 4.5	350 350	180 – 210 200 – 240

Recommended interpass temperature > 110°C

Approvals

SEPROZ