BÖHLER FOX BVD 90

Basic stick electrode for vertical-down welding, pipe welding

Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 55 5 Z2Ni B 4 5	E9018-G	E6218-G
	E9045-P2 (mod.)	E6245-P2 (mod.)

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. Special design and development work has enabled this electrode to provide exceptional striking characteristics and the avoidance of start porosity on cover (cap) passes. Due to this and the good welding characteristics this special basic electrode offers easy handling even under field conditions. Deposition rate is 80 – 100 % higher than for vertical up welding.

Base materials

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

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

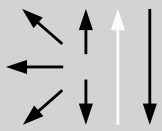
	C	Si	Mn	Ni
wt-%	0.05	0.3	1.2	2.2

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	±0 °C	–20 °C	–40 °C	–50 °C
u	**600** (≥ 550)	**650** (620 – 780)	**27** (≥ 18)	**170**	**145**	**130**	**110**	**80** (≥ 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 90 9018-G E 55 5 Z 2Ni B	3.2	350	110 – 160
			4.0	350	180 – 210
			4.5	350	200 – 240

Recommended interpass temperature > 90 °C

Approvals

TÜV (03402.), Statoil, SEPROZ, CE, GAZPROM ø 3.2; 4.0; 4.5 mm)