

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 50 4 1Ni B 1 2 H5	E 5516-G A H5	E8016-GH4R	E5516-GH4R

Characteristics and typical fields of application

Basic coated electrode excellent suited for positional welding for filler and cover passes for pipes, tubes and plates. Good impact properties down to -40 °C , low hydrogen content ($\text{HD} < 5\text{ ml}/100\text{ g}$), as well as packaging in hermetically sealed tins are further features for the user.

Base materials

EN: S235J2G3 - S355J2G3, L210NB - L450NB, L210MB - L450MB, P235GH - P295GH, E295, E335, S355J2G3, C35-C45, P310GH, S380N - S460N, P380NH-P460NH, S380NL - S460NL, S380NL1 - S460NL2, GE260-GE300

API Spec. 5 L: X 42, X46, **X 52, X 56, X 60, X 65**

ASTM A516 Gr. 65, A572 Gr. 55, 60, 65, A633 Gr. E, A612, A618 Gr. I, A537 Gr. 1-3

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

	C	Si	Mn	Ni
wt.-%	0.07	0.60	1.2	0.9

Mechanical properties of all-weld metal

Condition	Yield strength R_{eH}	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J				
	MPa	MPa	%	+20 °C	$\pm 0\text{ °C}$	-20 °C	-40 °C	-45 °C
u	550 (≥ 500)	590 (560 – 720)	29 (≥ 18)	170	150	140	110 (≥ 47)	60

u untreated, as welded

Operating data

	Polarity: DC (+)	Redrying if necessary: 300 – 350 °C, min. 2 h	Electrode identification: FOX EV 60 PIPE 8016-G E 50 4 1 Ni B	\varnothing (mm)	L mm	Amps A
				2.5	300	40 – 90
				3.2	350	60 – 130
				4.0	350	110 – 180
				5.0	450	180 – 230

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

Approvals

NAKS ($\varnothing 3.2\text{ mm}$), GAZPROM ($\varnothing 3.2\text{ mm}$)