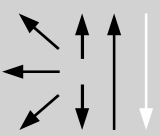


Classifications								
EN ISO 2560-A		EN ISO 2560-B		AWS A5.5		AWS A5.5M		
E 50 4 1Ni B 1 2 H5		E 5516-G A H5		E8016-GH4R		E5516-GH4R		
Characteristics and typical fields of application								
Basic coated electrode excellent suited for positional welding for filler and cover passes for pipes, tubes and plates. Good impact properties down to -40°C, low hydrogen content (HD < 5 ml/100 g), as well as packaging in hermetically sealed tins are further features for the user.								
Base materials								
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								
		C		Si		Mn		Ni
wt.-%		0.07		0.6		1.2		0.9
Mechanical properties of all-weld metal – typical values (min. values)								
Condi- tion	Yield strength R _{eH}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J				
				+20°C	±0°C	-20°C	-40°C	-45°C
u	540 (≥ 500)	620 (560 – 720)	26 (≥ 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	∅ 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								
CE								