

Classifications

EN ISO 2560-A	AWS A5.5 / SFA-5.5
E 42 0 Mo A 1 2	E7020-G

Characteristics and typical fields of application

BÖHLER FOX Black has a very thick acid coating for welding of special steels. The 0.5Mo weld metal offers a acicular ferrite and bainite microstructure with very low silicon content. Specially designed for welding of un-alloyed steels with subsequent hot-dip galvanization. High resistance against Zn-attack. The optimized Si-content avoids too excessive Zn deposit and colorating of the weld seam during galvanizing process.

Base materials

un-alloyed steels intended for galvanizing with yield strength up to 290 MPa

Typical analysis

	C	Si	Mn	Mo
wt.-%	0.10	0.08	0.60	0.45

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

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20° C	0° C
u	460 (≥ 420)	560 (500 - 640)	24 (≥ 20)	80	70 (≥ 47)

u untreated, as welded

Operating data

	Polarity	DC - / AC	Dimension mm	Current A
	Electrode identification	FOX Black / E 42 Mo A / E7020-G	4.0 × 450	140 – 190
			5.0 × 450	170 – 260

Approvals

CE