

## Classifications

EN ISO 2560-A	AWS A5.5 / SFA-5.5	EN ISO 2560-B	AWS A5.5M
E 50 6 Mn1Ni B 4 2 H5	E8018-G (E8018-C3 mod.)	E 5518-GA	E5518-G (E5518-C3 mod.)

## Characteristics and typical fields of application

Basic coated MnNi alloyed electrode. High toughness at temperatures as low as -60°C. High radio -graphical soundness; H<sub>2</sub>-content ≤ 5 ml/100 g (HD).

Particularly suitable for welding fine grained structural steels, for steel construction and bridge building applications, gas storage tanks.

## Base materials

Fine grained structural steels S355N - S500Q; low temperature fine grained structural steels P355NL1 – S500QL; low temperature special grades P355NL2 – S500QL1; general purpose structural steels; pipe steels L360NB – L415NB, L360MB – L485MB, X 52 – X 70; ASTM A516 Gr. 65, A572 Gr.55, 60, 65; A633 Gr. E; A612; A718 Gr. I, A537 Gr. 1 – 3

## Typical analysis

	C	Si	Mn	Ni
wt.-%	0.07	0.25	1.50	0.95


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

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-60°C
u	530 (≥ 500)	620 (560 - 720)	≥ 19	140	55 (≥ 47)
s	470	560	25	140	50

u untreated, as welded

s stress relieved 620 °C/2h / furnace down to 300 °C

## Operating data

	Polarity	DC +	Dimension mm	Current A
	Electrode identification	FOX EV 62 / E 50 6 Mn 1 Ni B / E8018-G	3.2 × 350	100 – 150
			3.2 × 350	
	Redrying	300 – 350°C/2h	4.0 × 350	140 – 180
			4.0 × 450	140 – 180
		5.0 × 450	170 – 250	

## Approvals

TÜV (00531), DB (10.014.58) ABS, BV, DNV, LR, VG 95132-1, CE