

## Classifications

EN ISO 18275-A	AWS A5.5 / SFA-5.5	AWS A5.5M
E 55 4 ZMn2NiMo B 1 2 H5	E9016-G H4R	E6216-G H4R

## Characteristics and typical fields of application

Basic coated electrode for high strength steels. It is excellent suited for positional welding of filler and cover passes of pipes, tubes and plates on D.C. positive polarity. It is user friendly with easy slag removal to ensure minimum grinding. Good impact properties down to -40°C, low hydrogen content (HD < 4 ml/100 g).

## Base materials

EN: L450MB, L485MB, L555MB  
API Spec. 5 L: X65, X70, X80

## Typical analysis

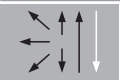
	C	Si	Mn	Ni	Mo
wt.-%	0.06	0.5	1.7	2.2	0.3

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

Condition	Yield strength $R_p$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J			
				20°C	-20°C	-40°C	-45°C
u	630 (≥ 550)	700 (620 – 780)	20 (≥ 18)	140	90	70 (≥ 47)	60

u untreated, as welded

## Operating data

	Polarity	DC ( + )	Dimension mm	Current A	
	Electrode identification	FOX EV 70 PIPE 9016-G		2.5 × 300	40 – 90
				3.2 × 350	60 – 130
			4.0 × 350	110 – 180	

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

## Approvals

TÜV (12809.), CE