BÖHLER FOX K 55

Stick electrode, unalloyed, basic coated

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1 / SFA-5.1	AWS A5.1M
E 46 4 B 3 2 H5	E 4916 A	E7016	E4916

Characteristics and typical fields of application

Good welding characteristics; clean weld metal with good toughness characteristics.
Prefered for rail joints and crossing frogs in railway and tramway trackage; suitable for rail grades with a tensile strength up to 1080 MPa; for mechanical engineering and tank construction.

Base materials

E295, E335, E360, C 45, C 60, GS-45, GS-52, GS-60,
P295GH, P355GH
Fine grained structural steels up to S355N;
Railway steels with up to 1080 MPa tensile strength

Typical analysis

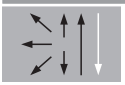
	C	Si	Mn
wt.-%	0.07	0.40	1.35

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	%	-40 °C
u	470 (≥ 420)	575 (≥ 530)	26 (≥ 19)	160 (=> 47)

u untreated, as welded

Operating data



Polarity	DC+ / AC
Electrode identification	FOX K 55 / E 46 4 B / E7016
Redrying	300 – 350°C/2h

Dimension mm	Current A
3.2 × 450	100 - 140
4.0 × 450	140 - 190
5.0 × 450	170 - 240
6.0 × 450	220 - 300

Approvals

TÜV (01807), DB (81.014.02), CE

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.