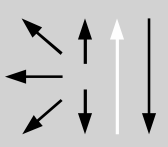


Classifications							
EN ISO 18275-A		AWS A5.5		AWS A5.5M			
E 62 5 Z2Ni B 4 5		E10018-G		E6918-G			
		E10045-P2 (mod.)		E6945-P2 (mod.)			
Characteristics and typical fields of application							
<p>Basic coated electrodes for vertical-down welds of large diameter pipelines and for structural work. Suitable for filler and cover pass welding in pipeline construction. Deposit is extremely crack resistant, and features high toughness and a very low hydrogen content. Special design and development work has enabled this electrode to provide exceptional striking characteristics and the avoidance of start. Due to this and the good welding characteristics this special basic electrode offers easy handling even under field conditions. Deposition rate is 80 – 100 % higher than for vertical up welding.</p>							
Base materials							
L555MB API Spec. 5 L: X80							
Typical analysis of all-weld metal							
	C	Si	Mn	Ni			
wt.-%	0.07	0.4	1.2	2.3			
Mechanical properties of all-weld metal – typical values (min. values)							
Condition	Yield strength $R_{eH}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J			
	MPa	MPa	%	+20 °C	-20 °C	-30 °C	-50 °C
u	<b>640</b> (≥ 620)	<b>720</b> (690 – 890)	<b>24</b> (≥ 18)	<b>150</b>	<b>120</b>	<b>105</b>	<b>60</b> (≥ 47)
u untreated, as welded							
Operating data							
	<b>Polarity:</b> DC ( + )	<b>Re-drying if necessary:</b> 300 – 350 °C / min. 2 h	<b>Electrode identification:</b> FOX BVD 100 10018-G E 62 5 Z2Ni B	ø mm	L mm	Amps A	
				4.0 4.5	350 350	180 – 210 200 – 240	
Recommended interpass temperature > 100°C							
Approvals							
TÜV (06333.), CE							