

Classifications

AWS A5.1

E7016

Characteristics and field of use

BÖHLER FOX S EV PIPE is a basic electrode suited for positional welding of root passes using both D.C. negative and D.C. positive polarity as well as for filler and cover passes of pipes, tubes and structural/plates.

Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	P	S
0.08	0.50	0.5	0.02	0.02

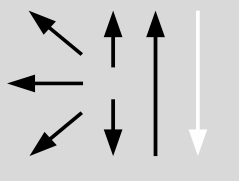
Base materials

S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB, X42 – X60; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52; SA 516 Gr 60, 65, 70; SA333 Gr 6.

Mechanical properties of the weld metal

Tensile strength	Yield Strength	Elongation	Impact strength
[MPa]	[MPa]	[%]	[-30°C,J]
560	490	30,0	47

Welding Position

	<p>Polarity DCEP (DCEN for root pass)</p>	<p>Re-drying if necessary: 300 – 350°C, min. 2 h. Preheated and interpass temperature as required by the base material. The optimum gap width for root passes is 2-3 mm, the root face should be in the range 2-2.5 mm.</p>
---	--	---

Size, Packing and Recommended welding parameters

Size (mm)	Carton Pack		Dry System		Amperage (A)
	Kg / Pack	Kg / Box	Kg / Pack	Kg / Box	
2.50 x 350	5.0	20.0	2.0	16.0	40- 90
3.25 x 350	5.0	20.0	2.0	16.0	60 - 130
4.00 x 350	5.0	20.0	2.0	16.0	110 -180