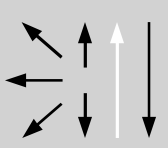


Classifications								
EN ISO 2560-A	EN ISO 2560-B	AWS A5.5			AWS A5.5M			
E 46 5 1Ni B 4 5 H5	E5545-P2 A U H5	E8045-P2H4R			E5545-P2H4R			
		E8018-GH4R			E5518-GH4R			
Characteristics and typical fields of application								
<p>Basic electrodes for vertical-down welds of large diameter pipelines and 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. Deposition rate is 80-100% higher than for vertical up welding. The weld deposit of BÖHLER FOX BVD 85 shows an ideal combination between high strength and cryogenic toughness down to -50°C (-58°F). Special design and development work has enabled this electrode to provide exceptional striking characteristics and the avoidance of start porosity. Due to this and the good welding characteristics this special basic electrode offers easy handling even under field conditions.</p> <p>Böhler Fox BVD 85 can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.</p>								
Base materials								
S235J2G3 - S355J2G3, L290NB - L450NB, L290MB - L450MB, P235GH - P295GH API Spec. 5 L:A, B, X 42, X46, X 52, X 56, X 60, X 65 , (X70)								
Typical analysis of all-weld metal								
	C	Si	Mn	Ni				
wt-%	0.05	0.4	1.1	0.9				
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	-40°C	-50°C
u	500 (≥ 460)	560 (550 – 680)	27 (≥ 20)	170	140	120	100	65 (≥ 47)
u untreated, as welded								
Operating data								
	Polarity: DC (+)	Re-drying if necessary: 300 – 350 °C / min. 2 h	Electrode identification: FOX BVD 85 8045-P2 E 46 5 1Ni B	ø mm	L mm	Amps A		
				3.2	350	110 – 160		
				4.0	350	180 – 210		
				4.5	350	200 – 240		
Recommended interpass temperature > 80 °C								
Approvals								
TÜV (03531.), CE								