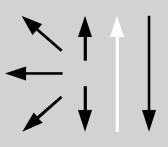


Classifications								
EN ISO 18275-A	EN ISO 18275-B	AWS A5.5			AWS A5.5M			
E 55 5 Z2Ni B 4 5 H5	E 6245-P2 A U H4 (mod.)	E9018-GH4R			E6218-GH4R			
		E9045-P2H4R (mod.)			E6245-P2H4R (mod.)			
Characteristics and typical fields of application								
Basic covered electrode for vertical-down welds 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 porosity. 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.								
Base materials								
L485MB, L555MB API Spec. 5 L: X70, X80								
Typical analysis of all-weld metal								
	C	Si	Mn	Ni				
wt.-%	0.05	0.3	1.2	2.2				
Mechanical properties of all-weld metal – typical values (min. values)								
Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J				
	MPa	MPa	%	+20°C	-20°C	-30°C	-40°C	-50°C
u	<b>580</b> (≥ 550)	<b>650</b> (620 – 780)	<b>27</b> (≥ 18)	<b>170</b>	<b>130</b>	<b>110</b>	<b>90</b>	<b>70</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 90 9018-G E 55 5 Z 2Ni B	ø mm	L mm	Amps A		
				2.5	350	80 – 110		
				3.2	350	110 – 160		
				4.0	350	180 – 210		
				4.5	350	200 – 240		
Recommended interpass temperature > 90 °C								
Approvals								
TÜV (03402.), CE, GAZPROM								