

EN 499:1994: E 42 5 B 1 2 H5  
 AWS A5.1-04: E7016-1H4R  
 AWS A5.1M-04: E4916-1H4R

# BÖHLER FOX EV 50-W

SMAW stick electrode, mild steel,  
 basic-coated

## Description

Basic coated electrode for high-quality joint welds. Especially suited for root pass welding. Excellent weldability in all positions except vertical-down. Smooth and slag-free welds. Crack resistant deposits of high toughness at ambient and subzero temperatures. Very low hydrogen contents in the weld deposit (according AWS condition HD < 4 ml/100 g weld metal). Especially suited for welding on AC. For root pass welding, DC negative polarity is recommended.

## Typical Composition of All-weld Metal

wt-%	C	Si	Mn
	0.07	0.5	1.1

## Mechanical Properties of All-weld Metal

(*)	u	s
Yield strength $R_e$ N/mm <sup>2</sup> :	460 (≥ 420)	400
Tensile strength $R_m$ N/mm <sup>2</sup> :	560 (510 - 640)	520
Elongation A ( $L_0 = 5d_0$ ) %:	28 (≥ 25)	28
Impact work ISO-V KV J	+ 20 °C:	200 (≥ 110)
	- 20 °C:	150
	- 40 °C:	120
	- 50 °C:	130 (≥ 47)

(\*) u untreated, as-welded

s stress relieved 580 °C/2 h/furnace down to 300 °C/air

## Operating Data



re-drying if necessary:  
**300 - 350 °C, min. 2 h**  
 Electrode identification:  
**FOX EV 50-W 7016-1 E 42 5 B**

ø mm	L mm	amps A
2.0	300	40 - 60
2.5	350	55 - 85
3.2	350	80 - 140
4.0	350	110 - 180
5.0	450	180 - 230



Polarity negative for root pass

## Base Materials

steels up to a yield strength of 420 N/mm<sup>2</sup> (60 ksi)

S235JR-E335, S235J2G3 - S355J2G3, C22, P235T1-P355T1, P235T2, P355T2, L210 - L360NB, L290MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JR S1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE260, GE300

ASTM A27 a, A36 Gr. all; A214; A 242 Gr. 1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. all; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42 - X56

## Approvals and Certificates

TÜV-D (4180.), CL (0498), FI (E 42 2 B 12 H5), GL (3YH5), UDT, LTSS, PDO, SEPROZ

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