BOHLER FOX N EV 48-1

Basic Coated Unalloyed Stick Electrode

Classification

AWS A5.1	AWS A5.1M	EN ISO 2560-A	EN ISO 2560-B	IS 814
E 7018-1	E 4918-1	E 42 5 B 3 2 H5	E 49 18 AP H5	EB 56 26 H3 JX

Characteristics and field of use

- Basic coated electrode with excellent welding characteristic and positional welding
- Tough weld with high impact strength at -45 ˚C.
- Weld metal recovery about 115%, thus higher productivity.
- Extremely good slag detachability thus greater welder comfort.
- Low spatter and finely rippled bead with regular profile reduces post weld dressing operations.
- Weld of consistent radiographic quality is achieved.

Base Materials

S235JR-E335, S235J2G3-S355J2G3, C22, P235T1-P355T1, P235T2, P355T2, L210-L360NB, L290MB-L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1-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. 60,70; A516 Gr. 55,70; A570 Gr. 30,33,36,40,45; A572 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

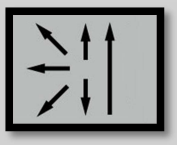
Typical Composition of all weld metal (wt. - %)

C	Si	Mn	S	P	Cr	Mo	Ni
0.045	0.45	1.30	0.015	0.024	0.020	0.003	0.015

Mechanical Properties of all weld metal

Heat treatment (PWHT), °C/Hr	Yield strength R_e N/mm^2	Tensile strength R_m N/mm^2	Elongation (L_0=4d_0)	Impact Test Values @ -45˚C
	MPa	MPa	%	J
As Welded	465	562	28	90
PWHT (610°C / 12hrs)	436	536	30	62

Operating data

Position	Polarity	Re-drying/baking conditions:	Ø(mm)	L	Amps
	DCEP /AC (>70V)	Re-drying at 250-350˚C for 2-3 Hrs recommended.	2.50 3.15 4.00 5.00	350 350/450 450 450	70 -110 100-140 130-180 180-230

Size & Packaging	Size	Kg./Pack	Kg./Box
	2.50x350	5.0	20.0
	3.15x350/450	5.0	20.0
	4.00x450	5.0	20.0
	5.00x450	5.0	20.0

Approvals

IBR, LRS, IRS, ABS