

## Classifications

EN ISO 18275-A	EN ISO 18275-B	AWS A5.5 / SFA-5.5	AWS A5.5M
E 55 5 Z2Ni B 4 5 H5	E 6245-P2 A U H4 (mod.)	E9018-GH4R	E6218-GH4R
		E9045-P2 H4R (mod.)	E6245-P2 H4R (mod.)

## Characteristics and typical fields of application

Basic coated 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


	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 energy ISO-V KV J				
	MPa	MPa	%	20°C	-20°C	-30°C	-40°C	-50°C
u	580 (≥ 550)	650 (620 – 780)	27 (≥ 18)	170	130	110	90	70 (≥ 47)

u untreated, as welded

## Operating data

	Polarity	DC ( + )	Dimension mm	Current A
	Electrode identification	FOX BVD 90 9018-G E 55 5 Z 2Ni B	2.5 x 350	80 - 110
	Redrying	if necessary: 300 – 350 °C / min. 2 h	3.2 x 350	110 – 160
			4.0 x 350	180 – 210
			4.5 x 350	200 – 240

Recommended interpass temperature > 90°C

## Approvals

TÜV (03402.), CE