

## **BÖHLER FOX EV 100**

Stick electrode low-alloyed, high strength

QT-steels, low a	CrMo B 4 2 F s and typica ectrode with teels. The ductility do prpass temper very low hydro tempered fin alloyed up to	al fields of ap high ductility own to –40 °C erature and p rogen conten ne-grained co 1000 MPa te	8-G and crac C. Easy w ost weld ts (HD < nstructio ensile str	cking resistan veld ability in heat treatme 5 ml/100 g). nal steels wit	all po nt as	ositions e required	G trength except v d by the	vertica base	al-down. e metal.	
Characteristics Basic coated electronstructional st Low-temperature Preheating, inter Deposits have very Base materials Quenched and t QT-steels, low a	s and typica ectrode with teels. re ductility do rpass tempe very low hyde tempered fin alloyed up to	al fields of ap high ductility own to –40 °C erature and p rogen conten ne-grained co 1000 MPa te	oplicatio and crac C. Easy w ost weld ts (HD < nstructio ensile str	cking resistan veld ability in heat treatme 5 ml/100 g). nal steels wit	all po nt as	or high-s ositions e required	trength except \ d by the	vertica base	al-down. e metal.	
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Quenched and t QT-steels, low a	tempered fin alloyed up to	1000 MPa te	ensile str		h 89(	) MPa yi	eld stre	ngth,		
QT-steels, low a	alloyed up to	1000 MPa te	ensile str		h 89(	) MPa yi	eld stre	ngth,		
Quenched and tempered fine-grained constructional steels with 890 MPa yield strength, QT-steels, low alloyed up to 1000 MPa tensile strength, XABO 890 <b>Typical analysis of all-weld metal (wt%)</b>										
		•	,							
C	Si	Mr	١	Cr	Ni		Мо		V	
wt% 0.0	6 0.3	35 1.7	7	0.7	2.5		0.5		0.07	
Mechanical pro	operties of a	all-weld meta	al							
Condition Yiel R <sub>p0,1</sub>	ld strength	Tensile strength $R_m$		Elongation A $(L_0=5d_0)$	Impact w ISO-V K					
MPa	MPa MPa			% -		+20 °C		–40 °C		
u ≥ 89	ı ≥ 890 9		980 – 1180		≥ 15 ≥		2 47		≥ 47	
u untreated, as welded										
Operating data	l									
Î Î DC (+) n		300 – 350 °C, FOX		Electrode lentification: EV 100 12018-G 4 Mn2Ni1CrMo B		<b>ø (mr</b> 3.2 4.0 5.0	3	<b>mm</b> 50 50 50	<b>Amps A</b> 100 – 140 140 – 180 190 – 230	
Approvals										
TÜV (07629.), VG 95132, CE										