

EN ISO 2560-A: E 42 3 B 4 2 H5
AWS A5.1: E7018-H4

BÖHLER FOX 7018

SMAW stick electrode, unalloyed, basic coated

Description

Basic coated electrode engineered for high-quality welds. Excellent strength and toughness properties down to -30°C. Also suitable for welding steels with low purity and high carbon content. Metal recovery about 115%. Good weldability in out-of-position work except for vertical-down. Suitable for welding in steel construction, boiler and container fabrication, vehicle construction, shipbuilding, and machine construction as well as for buffer layers when building up on high carbon steels. Deposit has very low hydrogen content (according to AWS condition HD ≤4 ml/100g weld metal).

Typical composition of All-weld Metal

	C	Si	Mn
wt-%	0.07	0.5	1.1

Mechanical properties of All-weld Metal

(*)	u
Yield strength R_e N/mm ² (MPa):	490
Tensile strength R_m N/mm ² (MPa):	600
Elongation A ($L_0=5d_0$) %:	24
Impact strength ISO-V KV J +20°C:	150
-30°C:	60

(*) u untreated, as welded

Operating Data



re-drying if necessary:

300-350°C, min. 2 h

Electrode identification:

FOX 7018

ø mm	L mm	amps A
2.5	250/350	80-110
3.2	350/450	100-140
4.0	450	130-180
5.0	450	180-230



Base Materials

S235JR-E335, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2, P355T2, L210-L360NB
L290MB-L32MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1-S235J4S,
S355G1S-S355G3S, S255N-S355N, P255NH-P355NH, S255NL-S355NL, GE200-GE260, GE300

ASTM A 27 u. 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; 60, 65, 70; 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, X52

Approvals

TÜV-D, CE, DNV, ABS