

EN 757: E 55 3 MnMo B T 4 2 H10
 AWS A5.5-96: E 9018-G
 E 9018-D1 (mod.)
 1) DIN 8529: E SY 55 43 MnMoB
 1) BS 2493: MnMoBH
 1) NFA 81-340: E Y 55 2 MnMoB 110 20 BH

BÖHLER FOX EV 70 Mo

**SMAW stick electrode
 low-alloyed, high strength**

¹⁾ replaced by EN 757

Description

Basic coated Mn-Mo alloyed electrode especially suited for high-strength fine-grained constructional steels and high-temperature steels, e.g. 15NiCuMoNb5S. Crack resistant, tough and ageing resistant.

Excellent weldability in all positions except vertical-down. Low hydrogen content in the deposit (HD <10ml/100 g).

Typical Composition of All-weld Metal

	C	Si	Mn	Mo
wt-%	0.06	0.4	1.6	0.5

Mechanical Properties of All-weld Metal

	u	s
yield strength R_e N/mm ² :	580 (≥550)	580 (≥550)
tensile strength R_m N/mm ² :	680 (620-780)	650 (620-760)
elongation A ($L_0=5d_0$) %:	22 (≥20)	23 (≥20)
impact work ISO-V KV J	+20°C: 150 (≥120)	160 (≥120)
	-30°C: 85 (≥47)	90 (≥47)

u untreated, as-welded

s stress relieved 650°C/15h/furnace down to 300°C/air

Operating Data



re-drying: 300-350°C, min. 2 h

electrode identification:

FOX EV 70 Mo 9018-G E 55 3 MnMo B T

ø mm	L mm	amps A
2.5	250	70-100
3.2	350	110-140
4.0	450	140-180
5.0	450	180-240



Base Materials

high-strength fine-grained steels, rail steels up to R0800 (for joint welding)

E295-E360, C35-C60, P310GH, 17MnMoV6-4, 15NiCuMoNb5S, S380N-S500N, P380NH-S500NH, GE300-GE340, 22Mo4

ASTM A225 Gr. C, A302 Gr. A-D, A514 and A517 Gr. A, B, C, E, F, H, J, K, M, P)

Approvals and Certificates

TÜV-D, TÜV-Ö, DB (10.014.11), ÖBB (10.01.010, 20.01.011), CL, Ü, SEPROS