

## **BÖHLER FOX FF**

Basic stick electrode, high-alloyed, heat resistant

Classification					
EN ISO 3581-A	EN ISO 3581-B	AWS A5.4			
E 22 12 B 2 2	ES309-15	E309-15			

## Characteristics and typical fields of application

Basic electrode core wire alloyed for welding analogous, heat resistant rolled, forged and cast steels as well as heat resistant ferritic CrSiAl steels. For weld joints exposed to reducing, sulphurous gases, the final layer has to be deposited by means of FOX FA, e.g. in annealing plants, hardening plants, steam boiler construction, the crude oil industry and the ceramics industry. Scaling resistant up to +1000°C.

## **Base materials**

Austenitic 1.4828 X15CrNiSi20-12, 1.4826 G-X40CrNiSi22-9, 1.4833 X7CrNi23-14

Ferritic-perlitic 1.4713 X10CrAl7, 1.4724 X10CrAl13, 1.4742 X10CrAl18, 1.4710 G-X30CrSi6, 1.4740 G-X40CrSi17 AISI 305, ASTM A297HF

Typical analysis of all-weld metal (wt%)									
	С	Si		Mn		Cr		Ni	
wt%	0.1		1.0			22.5		12.2	
Mechanical properties of all-weld metal									
Condition	Yield streng $R_{p0,2}$	th	Tensile s R <sub>m</sub>	trength	Elong A (L <sub>0</sub> :	ation =5d <sub>0</sub> )	Im IS	pact work O-V KV J	
	MPa		MPa		%		+2	2° 0°	ĺ

35 (≥ 25)

80

untreated, as welded u

**440** (≥ 350)

**Operating data** 

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	Polarity:	Electrode	ø (mm)	L mm	Amps A
	DC ( + )	identification:	2.5	300	50 – 75
	FOX FF E 22 12 B	3.2	350	80 - 100	
			4.0	350	110 – 140

**600** (≥ 550)

Preheating and interpass temperatures for ferritic steels 200 - 300 °C

## **Approvals**

TÜV (9090.), SEPROZ, CE