

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 42 3 C 2 5	E 49 10-P1 A U	E7010-P1	E4910-P1

Characteristics and typical fields of application

Cellulose electrode for vertical-down welding of high strength large diameter pipelines. Especially recommended for hot passes, filler and cover layers. Highly economical compared with conventional vertical-up welding. The penetrating arc characteristics and the low slag formation allow good bead control and ensure best performance in all positions even with the larger diameter electrodes and high amperages.

BÖHLER Fox CEL 75 can be used in sour gas applications (HIC-Test acc. NACE TM-02-84). Test values for SSC-test are available too.

Base materials

S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210-L415NB, L290MB – L415MB, P355T1, P235T2 - P355T2, P235G1TH, P255G1TH root pass up to L480MB

API Spec. 5 L: Grade A, B, X42, X 46, X 52, X 56, X 60, Root pass up to X 70

Typical analysis of all-weld metal (wt.-%)

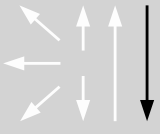
	C	Si	Mn
wt-%	0.14	0.14	0.7

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J				
	MPa	MPa	%	+20 °C	± 0°C	-20 °C	-30 °C	-40 °C
u	480 (≥ 420)	550 (500 – 640)	23 (≥ 22)	100	95	65	55 (≥ 47)	45

u untreated, as welded

Operating data

	Polarity:	Redrying:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (+) /	not allowed	FOX CEL 75	3.2	350	80 – 130
	DC (-)		7010-P1 E 42 3 C	4.0	350	120 – 180
	polarity negative for root pass			5.0	350	160 – 210

Approvals

TÜV (533)