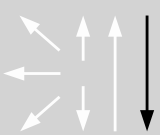


Classifications						
EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M			
E 46 3 1Ni C 2 5	E 55 10-P1 A U	E8010-P1	E5510-P1			
Characteristics and typical fields of application						
<p>Cellulose electrode for vertical-down welding of high strength, large diameter pipelines. Highly economical compared with conventional vertical-up welding. Especially recommended for hot pass, filler and cover layers. The BÖHLER FOX CEL 80-P provides a more intensive arc and a more fluid weld metal as compared to the well known BÖHLER FOX CEL 85.</p> <p>BÖHLER FOX CEL 85 can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.</p>						
Base materials						
L415NB - L485NB, L415MB - L485MB						
API Spec. 5 L: X 56, X 60, X 65, X 70						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Ni		
wt-%	0.15	0.15	0.7	0.8		
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	-20 °C	-30 °C
u	490 (≥ 460)	580 (550 – 680)	23 (≥ 20)	90	80	60 (≥ 47)
u untreated, as welded						
Operating data						
	Polarity:	Redrying:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (+)	not allowed	FOX CEL 80-P	3.2	350	60 – 130
			8010-P1 E 46 3 1Ni C	4.0	350	100 – 180
				5.0	350	140 – 210
Approvals						
TÜV (11181.), CE						