

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 46 4 1Ni C 2 5	E 55 10-P1 A U	E8010-P1	E5510-P1

Characteristics and typical fields of application

Cellulose electrode for vertical-down welding of high strength large diameter pipelines. Highly economical compared with conventional vertical-up welding.

Especially recommended for hot passes, filler and cover layers. Without doubt BÖHLER FOX CEL 85 is the most popular cellulosic electrode which meets all the exacting demands of the field welding of cross country pipelines extremely well. It ensures highest joint weld quality down to temperatures of $-40\text{ }^{\circ}\text{C}$.

BÖHLER FOX CEL 85 can be used in sour gas applications (HIC-Test acc. NACE TM-02-84). Test values for SSC-test are available too.

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.-%)

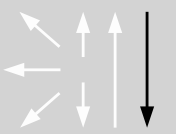
	C	Si	Mn	Ni
wt-%	0.14	0.15	0.75	0.7

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	$\pm 0\text{ }^{\circ}\text{C}$	-20 °C	-40 °C
u	490 (≥ 460)	570 (550 – 680)	23 (≥ 20)	110	105	100	70 (≥ 47)

u untreated, as welded

Operating data

	Polarity:	Redrying:	Electrode identification:	\varnothing (mm)	L mm	Amps A	
	DC (+)	not allowed		3.2	350	80 – 130	
				FOX CEL 85 8010-P1	4.0	350	120 – 180
				E 46 4 1Ni C	5.0	350	160 – 210

Approvals

TÜV (01361.), ABS (E 8010-P1), SEPROZ, CE