

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5M	AWS A5.5 / SFA-5.5
E 42 3 C 2 5	E49 10-P1 A U	E4910-P1	E7010-P1

Characteristics and typical fields of application

Cellulose electrode for vertical-down welding of 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 also with high amperages.

The weld metal has excellent impact values and welding is easy also under difficult weather conditions.

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

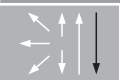
	C	Si	Mn
wt.-%	0.14	0.14	0.7

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J			
	MPa	MPa	%	20°C	0°C	-20°C	-30°C
u	460 (≥ 420)	550 (500 – 640)	23 (≥ 22)	100	95	65	60 (≥ 47)

u untreated, as welded

Operating data

	Polarity	DC+/-, Minuspol für Wurzel	Dimension mm	Current A
	Electrode identification	FOX CEL 75 7010-P1 E 42 3 C	3.2 × 350	80 – 130
			4.0 × 350	120 – 180
		5.0 × 350	160 – 210	

Approvals

CE