BÖHLER FOX CEL 80-P

Cellulosic stick electrode, for vertical-down welding, pipe welding

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/E8010-G	E5510-P1/E5510-G

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 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.

BÖHLER FOX CEL 80-P can also be used in sour gas applications (HIC-Test acc. to 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

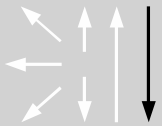
	C	Si	Mn	Ni
wt.-%	0.15	0.15	0.7	0.8

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 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 8010-P1/-G E 46 3 1Ni C	3.2	350	60 – 130
			4.0	350	100 – 180
			4.8	350	130 – 200
			5.0	350	140 – 210

Approvals

TÜV (11181.), CE