BÖHLER FOX CEL 90

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 50 3 1Ni C 2 5	E 57 10-G A	E9010-P1	E6210-P1
		E9010-G	E6210-G

Characteristics and typical fields of application

Cellulose-coated 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. The special design of the coating and the core wire guarantees the highest metallurgical quality & soundness of the weld metal deposit with excellent mechanical properties. The electrode allows good weld pool visability, and easy manipulation, as well as high safety margins against porosity and slag inclusions.

BÖHLER FOX CEL 90 can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.

Base materials

L450MB, L485MB

API Spec. 5 L: X 65, X 70, (X 80)

Typical analysis of all-weld metal

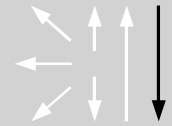
	C	Si	Mn	Ni
wt.-%	0.17	0.15	0.9	0.8

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

Condition	Yield strength R_{eH}	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	**560** (≥ 530)	**650** (620 – 720)	**21** (≥ 18)	**100**	**90**	**75**	**65** (≥ 47)	**40**

u untreated, as welded

Operating data



Polarity:	Redrying:	Electrode identification:	ø mm	L mm	Amps A
DC (+)	not allowed	FOX CEL 90 9010-P1 E 50 3 1Ni C	4.0	350	120 – 180
			5.0	350	160 – 210

Approvals

TÜV (01324.), CE