

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 38 3 C 2 1	E 43 10 A U	E6010	E4310

Characteristics and typical fields of application

Cellulose electrode for vertical-down welding of large diameter pipelines; suitable for root runs (vertical down and vertical up), hot passes, filler and cover layers. Especially recommended for root run welding. Highly economical compared with vertical-up welding. Apart from its excellent welding and gap bridging characteristics FOX CEL offers a weld deposit with outstanding impact strength values and thus offers the benefit of still more safety in field welding of pipelines. BÖHLER FOX CEL 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, P355T1, P235T2-P355T2, L210NB - L415NB, L290MB - L415MB, P235G1TH, P255G1TH
root pass up to L555NB, L555MB

API Spec. 5 L: A, B, X 42, X 46, X 52, X 56, Root pass up to X 80

Typical analysis of all-weld metal (wt.-%)

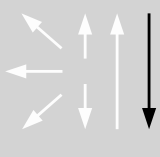
	C	Si	Mn
wt-%	0.12	0.14	0.5

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	±0 °C	-20 °C	-30 °C
u	450 (≥ 390)	550 (470 – 600)	26 (≥ 22)	100	90	80	50 (≥ 47)

u untreated, as welded

Operating data

	Polarity:	Redrying:	Electrode identification:	∅ (mm)	L mm	Amps A
	DC (+) / DC (-)	not allowed	FOX CEL 6010	2.5	250/300	50 – 90
	polarity negative for root pass		E 38 3 C	3.2	350	80 – 130
				4.0	350	120 – 180
				5.0	350	160 – 210

Approvals

TÜV (01281.), DNV (3), Statoil, SEPPOZ, CE, NAKS (∅ 3.2; 4.0 mm)