

Classifications

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

Characteristics and typical fields of application

Cellulose electrode for vertical-down welding of high strength large diameter pipelines. Especially recommended for hot passes, filler and cover layers. Highly economical compared with conventional vertical-up welding. The BÖHLER FOX CEL 70-P provides a more intensive arc and a more fluid weld metal as compared to the well-known BÖHLER FOX CEL 75.

BÖHLER FOX CEL 70-P 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

S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210-L415NB, L290MB-L415MB, L450MB, P355T1, P235T2-P355T2, P235G1TH, P255G1TH

API Spec. 5L: Grade A, B, X42, X 46, X52, X56, X60, X65, root pass up to X80

Typical analysis

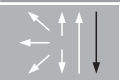
	C	Si	Mn	Ni
wt.-%	0.15	0.10	0.45	0.17

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	-20°C	-30°C
u	460 (≥ 420)	560 (500 – 640)	23 (≥ 22)	100	80	65 (≥ 47)

u untreated, as welded

Operating data

	Polarity	DC(+), DC (-), root pass welding in vertical up or vertical down	Dimension mm	Current A
	Electrode identification	FOX CEL 70-P 7010-P1 E 42 3 C	3.2 × 350	60 – 130
			4.0 × 350	100 – 180
			4.8 × 350	130 – 200
			5.0 × 350	140 – 210

Approvals

TÜV (11180), CE