

ENISO 2560-A:2005: E 46 4 1Ni C 25
 ENISO 2560-B:2005: E 55 10-P1 A U
 AWS A5.5-96: E8010-P1

BÖHLER FOX CEL 85

SMAW cellulosic electrode for
 vertical-down welding, pipe welding

Description

Cellulose 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. Without doubt BÖHLER FOX CEL 85 is the most popular cellulosic electrode which meets all the exacting demands of the field welding of cross country pipelines extremely well. It ensures highest joint weld quality down to temperatures of -40 °C

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

Typical Composition of All-weld Metal

	C	Si	Mn	Ni
wt-%	0.14	0.15	0.75	0.7

Mechanical Properties of All-weld Metal

(*)		u	
yield strength R_e N/mm ² :		490	(\geq 460)
tensile strength R_m N/mm ² :		570	(550 - 650)
elongation A ($L_0 = 5d_0$) %:		23	(\geq 20)
impact work ISO-V KV J	+ 20 °C:	110	(\geq 80)
	± 0 °C:	105	
	- 20 °C:	100	
	- 40 °C:	70	(\geq 47)

(*) u untreated, as-welded

Operating Data



re-drying: **not allowed**
 electrode identification:
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 preheating and interpass temperature
 see Page 2-49

ø mm	L mm	amps A
3.2	350	80 - 130
4.0	350	120 - 180
5.0	350	160 - 210



Base Materials

L415NB - L485NB, L415MB - L485MB
 API Spec. 5 L: X 56, X 60, X 65, X 70

Approvals and Certificates

TÜV-D (1361.), TÜV-A (3), ABS (E 8010-P1), FI (E 46 4 1Ni C 25), GdF (X), SEPROZ,
 GdFø 3.2;4.0;5.0 mm, PDO, CE