

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 42 3 Mo C 2 5	E 49 10-M3 A	E7010-A1	E4910-A1

Characteristics and typical fields of application

Mo-alloyed cellulose covered 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.

Excellent weld-metal toughness, easy welding, with an intensive arc and a deep penetration in order to ensure sound joint welds with good X-ray quality.

BÖHLER FOX CEL Mo 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, L210-L415NB, L290MB-L415MB, P355T1, P235T2-P355T2, P235G1TH, P255G1TH

Root pass up to L555MB

API Spec. 5 L: Grade A, B, X 42, X 46, X 52, **X 56, X 60**, Wurzel bis X 80

Typical analysis of all-weld metal

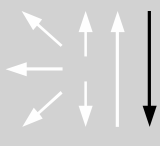
	C	Si	Mn	Mo
wt.-%	0.1	0.14	0.4	0.5

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				
				+20 °C	±0 °C	-20 °C	-30 °C	-40 °C
u	480 (≥ 420)	550 (500 – 640)	23 (≥20)	100	95	85	50 (≥ 47)	42

u untreated, as welded

Operating data

	Polarity:	Redrying:	Electrode identification:	ø mm	L mm	Amps A
	DC (+) / DC (-)	not allowed	FOX CEL Mo	3.2	350	80 – 130
	polarity negative for root pass		7010-A1 E 42 3	4.0	350	120 – 180
			Mo C	5.0	350	160 – 210

Approvals

TÜV (01325.), ABS, CE