BÖHLER FOX CEL 85 G

Cellulosic stick electrode, for vertical-down welding, pipe welding

Classifications

AWS A5.5	AWS A5.5M
E8010-G	E5510-G

Characteristics and typical fields of application

Cellulose-coated electrode for vertical-down welding of high strength large diameter pipelines. Especially recommended for hot passes, filler and cover layers. Highly economical compared with vertical-up welding. The electrode provides consistently high quality as well as outstanding low temperature toughness values together with superior operating characteristics.

Base Materials

L415NB - L485NB, L415MB - L485MB

API Spec. 5 L: X 56, **X 60, X 65, X 70**

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

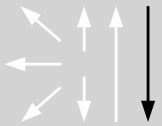
	C	Si	Mn	Ni
wt-%	0.15	0.15	0.7	0.8

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	–30 °C
u	**490** (≥ 460)	**580** (≥ 550)	**23** (≥ 19)	**90**	**85**	**60**

u untreated, as welded

Operating data



Polarity:	Redrying:	Electrode identification:	ø (mm)	L mm	Amps A
DC (+)	not allowed	FOX CEL 85 G 8010-G	3.2	350	60 – 130
			4.0	350	100 – 180
			5.0	350	140 – 210

Interpass temperature: Adjusting to base material & wall thickness.