

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

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. Besides the excellent weld metal toughness properties it offers easy operation, and a concentrated intensive arc with deep penetration characteristics 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**
Root pass up to X 80

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

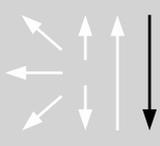
	C	Si	Mn	Mo
wt-%	0.1	0.14	0.4	0.5

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	-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:	∅ (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 (E 7010-A1), SEPROZ, CE