

Revisionsnummer: 1

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5 / SFA-5.5	AWS A5.5M
E 46 3 1Ni C 2 5	E5510-P1 A U	E8010-P1	E5510-P1
		E8010-G	E5510-G

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 pass, filler and cover layers. The BÖHLER FOX CEL 80-P provides a more intensive arc and a more fluid weld metal as compared to the well-known BÖHLER FOX CEL 85.

BÖHLER FOX CEL 80-P can also be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.

Base materials

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

Typical analysis


	C	Si	Mn	Ni
wt.-%	0.15	0.15	0.7	0.8

Mechanical properties of all-weld metal - typical values (min. values)

Zustand	Streckgrenze R_e	Zugfestigkeit R_m	Dehnung A ($L_0=5d_0$)	Kerbschlagarbeit ISO-V KV J		
	MPa	MPa	%	20°C	-20°C	-30°C
u	490 (≥ 460)	580 (550 – 680)	23 (≥ 20)	90	80	60 (≥ 47)

u unbehandelt, Schweißzustand

Operating data

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	FOX CEL 80-P 8010-P1 E 46 3 1Ni C	3.2 × 350	60 – 130
	Redrying	not allowed	4.0 × 350	100 – 180
			4.8 × 350	130 – 200
			5.0 × 350	140 – 210

Approvals

TÜV (11181.), CE