BÖHLER FOX CEL 85 — Stick electrode

Classifications		unalloyed cellulosic
EN ISO 2560-A:	AWS A5.5:	
E 46 4 1Ni C 2 5	E8010-P1	

Characteristics and field of use

Higher-strength, cellulose coated stick electrode for vertical down welding on large pipelines. Highly economical compared to vertical up welding. Particularly suitable for hot pass, filler and cover pass welding on higher-strength pipe steels. FOX CEL 85 is one of the most widely used cellulose electrodes, and meets the highest quality demands in large pipeline construction. It is characterised by a very intensive, fine-droplet depositing, as well as good toughness properties. Insensitive to weather conditions, high resistance to the formation of shrinkage grooves. HIC and SSC resistance tested according to NACE TM 02-84 or TM 01-77.

Base materials

L415NB-L450NB, L415MB-L450MB API Spec. 5 L: X 56, X 60, X 65

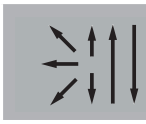
Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Ni	
0,14	0,15	0,75	0,7	

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0,2%	Tensile strength	Elongation (L_0=5d_0)	Impact values in J CVN			
	MPa	MPa	%	+20°C:	±0°C:	-20°C:	-40°C:
untreated	490	570	23	110	105	100	70

Operating data



Polarity = +

Dimensions (mm)	Amperage A
3,2 x 350	80-130
4,0 x 350	120-180
5,0 x 350	160-210

Approvals and certificates

TÜV-D (1361.), ABS (E8010-P1), SEPROZ, CE