

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5 / SFA-5.5	AWS A5.5M
E 50 3 1Ni C 2 5	E5710-G A	E9010-G	E6210-G
		E9010-P1	E6210-P1

Characteristics and typical fields of application

Cellulose-coated 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. The special design of the coating and the core wire guarantees the highest metallurgical quality and soundness of the weld metal deposit with excellent mechanical properties. The electrode allows good weld pool visibility, and easy manipulation, as well as high safety margins against porosity and slag inclusions.

BÖHLER FOX CEL 90 can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.

Base materials

L450MB, L485MB
API Spec. 5 L: X 65, X 70, (X 80)

Typical analysis


	C	Si	Mn	Ni
wt.-%	0.17	0.15	0.9	0.8

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

Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J				
				20°C	0°C	-20°C	-30°C	-40°C
u	560 (≥ 530)	650 (620 – 720)	21 (≥ 18)	100	90	75	65 (≥ 47)	40

u untreated, as welded

Operating data

	Polarity	DC (+)	Dimension mm	Current A	
	Electrode identification	FOX CEL 90 9010-P1 E 50 3		4.0 × 350	120 – 180
	1Ni C		5.0 × 350	160 – 210	

Approvals

TÜV (01324.), CE