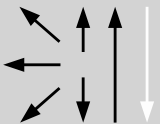


Classifications						
EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M			
E 42 3 C 2 5	E 49 10-P1 A U	E7010-P1	E4910-P1			
Characteristics and typical fields of application						
<p>Cellulose electrode for vertical-down welding of high strength large diameter pipelines. Especially recommended for hot passes, filler and cover layers. Highly economical compared with conventional vertical-up welding. The BÖHLER FOX CEL 70-P provides a more intensive arc and a more fluid weld metal as compared to the well known BÖHLER FOX CEL 75.</p> <p>BÖHLER FOX CEL 75 can be used in sour gas applications (HIC-Test acc. to NACE TM-02-84). Test values for SSC-test are available too.</p>						
Base materials						
<p>S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210-L415NB, L290MB-L415MB, P355T1, P235T2-P355T2, P235G1TH, P255G1TH</p> <p>API Spec. 5L: Grade A, B, X42, X 46, X52, X56, X60</p>						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Ni		
wt-%	0.15	0.10	0.45	0.17		
Mechanical properties of all-weld metal						
Condition	Yield strength R_{eH}	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-20 °C	-30 °C
u	460 (≥ 420)	550 (500 – 640)	23 (≥ 22)	100	80	65 (≥ 47)
u untreated, as welded						
Operating data						
	Polarity:	Redrying:	Electrode identification:	\varnothing (mm)	L mm	Amps A
	DC (+)	not allowed	FOX CEL 70-P	3.2	350	60 – 130
			7010-P1 E 42 3 C	4.0	350	100 – 180
				5.0	350	140 – 210