



# merian<sup>®</sup> BÖHLER FOX CEL 75

Cellulosic stick electrode, for vertical-down welding, pipe welding

## 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

Cellulose electrode for vertical-down welding of large diameter pipelines.

Especially recommended for hot passes, filler and cover layers. Highly economical compared with conventional vertical-up welding.

The penetrating arc characteristics and the low slag formation allow good bead control and ensure best performance even with the larger diameter electrodes and high amperages.

The weld metal has excellent impact values and welding is easy also under difficult weather conditions.

BÖHLER FOX CEL 75 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 L480MB

API Spec. 5 L: Grade A, B, X42, X 46, X 52, X 56, X 60, Root pass up to X 70

## Typical analysis of all-weld metal


	C	Si	Mn
wt.-%	0.14	0.14	0.7

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

Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J			
				+20 °C	± 0°C	-20 °C	-30 °C
u	<b>460</b> (≥ 420)	<b>550</b> (500 – 640)	<b>23</b> (≥ 22)	<b>100</b>	<b>95</b>	<b>65</b>	<b>60</b> (≥ 47)

u untreated, as welded

## Operating data

	Polarity:	Redrying:	Electrode identification:	ø mm	L mm	Amps A
	DC +	not allowed	FOX CEL 75	3.2	350	80 – 130
	DC –		7010-P1 E 42 3 C	4.0	350	120 – 180
	negative polarity for root pass			5.0	350	160 – 210

## Approvals

CE