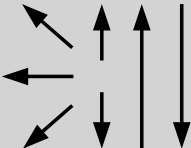


Classifications					
EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M		
E 50 3 1 Ni C 2 5	E 5710 G	E9010-G	E6210-G		
Characteristics and typical fields of application					
Cellulose covered electrode for circumferential welds; developed for field welding of higher strength pipeline steels in the vertical down position. Excellent weldability in root, hot, fill and cap pass welding.					
Base materials					
API5L: X 60, X 65, X 70, (X 80) EN 10208-2: L415MB-, L450MB-, L485MB-, (L555MB-) und NB-qualities Phoenix Cel 90 is overmatching the X 60 and X 65 steels					
Typical analysis of all-weld metal (wt.-%)					
	C	Si	Mn	Ni	
wt-%	0.18	0.20	0.85	0.75	
Mechanische Gütwerte des Schweißgutes					
Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	−20 °C
aw	530	630	18	70	55
				−30 °C	47
Operating data					
	Polarity: DC (+)	Redrying: Do not redry!	ø (mm)	L mm	Amps A
	for root pass DC (−)		3.2	350	80 – 140
			4.0	350	140 – 190
			5.0	350	160 – 220
Approvals					
TÜV (00105), CE					