

Phoenix Cel 90

Stick electrode

Classifications

unalloyed cellulosic

EN ISO 2560-A:

AWS A5.5:

E 50 3 1 Ni C 2 5

E9010-G

Characteristics and field of use

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. Easy slag removal. Good bend and radiographic test results. High ductility of the welded joint. Do not redry!

Base materials

API5L: X 60, X 65, X 70, (X 80) EN 10208-2: L415MB-, L450MB-, L485MB-, (L555MB-) and B-qualities; Phoenix Cel 90 is overmatching the X 60 and X 65 steels

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

C	Si	Mn	Ni	
0.18	0.20	0.85	0.75	

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation (L ₀ =5 ₀)	Impact values ISO-V		
	MPa	MPa	%	+20°C	-20°C:	-30°C
untreated	530	630	18	70	55	47

Operating data



Polarity = +/- -

Dimensions (mm)

Amperage A

3.2 x 350	80-140
4.0 x 350	140-190
5.0 x 350	160-220

Approvals and certificates

TÜV (00105.)