

Thick basic coated MMA electrode for producing hard facing deposits of medium hardness, which can be machined by chip-forming. Particularly suited for wear resisting parts subjected to heavy impact and shock. CITORAIL can be easily welded in all positions, except vertically-down. Weld metal is crack resistant and free of pores. Suitable for reconditioning of rails, rail crossings, switch points, sprockets and wearing parts, such as rope pulleys, tumblers, rollers, caterpillar track rollers and links, wheel flanges, stud links and others.

Classification	
DIN	8555: E 1 - UM - 300
EN	14700: E Fe1

Approvals	Grades
DB	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.10	0.80	1	-	-	3.20	-	-	-	Rem	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	275-325 HB

### Materials

Rails up to TS 855 N/mm<sup>2</sup>

### Storage and redrying

Keep dry and avoid condensation.

Re-drying recommended at 300-350 °C for 2 hours, 5 times max.

### Current condition and welding position

DC+; AC



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	70-100	19,8	11,9
3,2	450	110-130	44,7	26,8
4,0	450	140-180	65,6	39,4
5,0	450	190-240	104,0	62,4
6,0	450	210-280	147,8	88,7