

## Cored Wires C-Mn and low-alloy steels

Citoflex M00 is a high deposition rate metal cored wire. Excellent welding properties with both short and spray arc. Virtually spatter free in the spray-arc range. Particularly suitable for robotic applications. Characteristic features are: good edge wetting, finely rippled welds, little oxide formation on the weld surface making multipass welding possible without inter-run cleaning. The weld profile is easily controllable making this wire well suited for gap bridging and positional welding.

Classification	
AWS	A5.18: E 70 C-6M H4
EN	758: T 46 4 MM 1 H5

Approvals	Grades
DB	
DNV	
LRS	
RINA	
TÜV	

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	V	N	Cu
0.04	1.70	0.50	≤ 0.020	≤ 0.020	-	-	-	-	-	-	-

### 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) -40°C	Hardness
PWHT 620°C x 2h	≥ 460	530-680	≥ 22	≥ 80	-
As Welded	≥ 460	530-680	≥ 22	≥ 80	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21-Atal 6)

### Materials

S(P)235-S(P)460, GP240-GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC +				
				
PA	PB	PC	PF	PE

**Packaging data:** K300 kg, 16

Diameters	1,2					
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