

Cored Wires C-Mn and low-alloy steels

Citoflex M60 is a metal cored wire depositing a fine well shaped weld bead. High deposition rate and excellent weldability. No slag residue, suitable for single and multipass automatic welding. Main applications include mechanical constructions and earth moving equipment.

Diffusible hydrogen 5 ml/100g. max.

Classification	
AWS	A5.18: E 70-C6 M H4
EN	758: T 46 4 M M 1 H5

Approvals	Grades
BV	
DB	
DNV	
FI	
LRS	
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
0.05	1.50	0.60	≤ 0.020	≤ 0.020	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
PWHT 580°C x 2h	≥ 420	500-640	≥ 20	≥ 47	-
As Welded	≥ 460	530-680	≥ 20	≥ 47	-

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+



Packaging data: K300 kg. 16

Diameters	1,0	1,2	1,4	1,6		