

CITOFLEX M60 A

Cored Wires C-Mn and low-alloy steels

Citoflex M60 A is a metal cored wire which produces a fine aspect to the weld bead. High deposition rate and excellent arc stability with no slag residue, suitable for single and multipass automatic welding. The main applications are mechanical constructions and earth moving equipment.
Diffusible hydrogen 5 ml/100g, max.

Classification	
AWS	A5.18: E 70C-6 M H8
EN	758: T 42 2 MM 1 H5

Approvals	Grades
BV	
DNV	
LRS	

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
0.06	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) -30°C	Hardness
As Welded	≥ 420	500-640	≥ 20	≥ 60	-

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	1,2	1,6			