

CITOFLEX 6117

Cored Wires C-Mn and low-alloy steels

Citoflex 6117 is a rutile flux cored wire. The weld pool is easily controllable with outstanding welding properties. The enhanced filling results in increased current carrying capacity and hence deposition rate, thus increasing welding speed and leading to savings of time and costs. Low spatter loss and easy slag removal result in smooth and finely rippled welds without undercut.

Classification	
AWS	A5.20: E71T-1 M H4
EN	758: T 42 2 P M 1 H5

Approvals	Grades
RINA	

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	1.30	0.50	≤ 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) -20°C	Hardness
As Welded	≥ 420	500-640	≥ 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

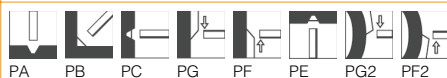
S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC +



Packaging data: K300 kg. 16

Diameters	1,2					
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