

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

Citoflex B 00 is a basic flux cored wire with excellent mechanical properties, suitable for the welding of heavy sections. Excellent low temperature impact toughness in both the as welded and stress-relieved conditions. Stable arc, spatter-free both in the flat and vertical positions. The weld deposit has a very low hydrogen content.

Classification	
AWS	A5.20: E 71T-5 MJ
EN	758: T 42 5 B M1 H5
EN	758: T 42 4 B C1 H5

Approvals	Grades
DNV	
LRS	
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
0.06	1.50	0.60	≤ 0.025	≤ 0.025	-	-	-	-	-	-	-

### 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) -50°C	Hardness
PWHT 580°C x 2h	≥ 420	500-640	≥ 20	≥ 60	-
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(Arcal21-Atal6) or C1(Arcal 2)

### 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	1,6				
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