

CITOFLUX B13-0

Cored Wires C-Mn and low-alloy steels

Citoflux B13-0 is self shielded flux cored wire for welding in all positions. It is used for on-site assembly of sheet and plate metal or profile sections (thickness 3 to 15mm), for the spot welding of round bars for reinforced concrete and for joining galvanized parts.

Classification	
AWS	A5.20: E71-T7
EN	758: T 42 Z Y 1 H15

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.30	0.60	0.15	-	-	-	-	-	-	-	-	-

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	≥ 540	≥ 22	≥ 30	-

Gas test: Without gas

Shielding Gas: Without gas

Materials







Fe E215; Fe E235

S(P)235; GP240

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-					
					
PA	PB	PC	PG	PF	PE

Packaging data: K300 kg. 16

Diameters	1,0	1,2	1,6			