

Cored Wires High-strength steels

Citoflex M20 is a metal cored wire containing nickel, for welding in all positions. Main applications: Off-shore fabrications, pipework, pressure vessels, shipbuilding (LPG tankers, ice breakers). Citoflex M 20 can be used for automatic multi-run welding. Diffusible hydrogen <3ml/100g of deposited weld metal.

Classification	
AWS	A5.29: E 81 T5-G H4
EN	758: T 46 6 Mn1Ni 1 M M H5

Approvals	Grades
DNV	

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
0.04	1.70	0.50	≤ 0.020	≤ 0.020	-	0.90	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -60°C	Hardness
PWHT 580°C x 2h	≥ 420	500-640	≥ 20	≥ 47	-
As Welded	≥ 460	530-680	≥ 20	≥ 80	-

Gas test: Acc. To EN 439: M21(Arcal 21)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

S(P)275-S(P)460

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		