

Citoflex H 06 is a basic tubular flux cored wire for hardfacing of wear parts, such as excavator components, scraper blades, dipper teeth, worm conveyors, beaters, crusher jaws, crusher cones, subjected to heavy wear. The weld metal is tough, free of cracks and therefore resistant to shock and impact. Machining is only possible by grinding.

Classification	
DIN	8555:MSG 6-GF-C1-60-GP
DIN	8555:MSG 6-GF-M21-60-GP

Approvals	Grades
DB	

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	Fe	W	Cu
0.45	0.40	2.60	-	-	9.50	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 320	≥ 520	-	-	35-40 HRC

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Storage

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,2	1,6				
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