

# CITOREX

## TOP FEATURES

- The welding current can be decreased to low values while maintaining a stable arc, good for gap-bridging.
- The excellent positional welding characteristics have established CITOREX as a first choice for welder training.
- Due to the low silicon content of the weld deposit, CITOREX is used to weld components for subsequent galvanising or enamelling.

## CLASSIFICATION

AWS A5.1 E6013  
EN ISO 2560-A E 38 2 RB 12

## CURRENT TYPE

AC, DC-

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

LR	DNV	TÜV
+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si
0.07	0.6	0.2

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C
AWS A5.1	AW	≥330	≥430	≥17	not specified
EN ISO 2560-A	AW	≥380	470-600	≥20	≥47
Typical values	AW	430	500	28	49

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 250	40-60
2.5 x 300	50-90
3.2 x 350	100-150
4.0 x 350	140-190
4.0 x 450	140-190
5.0 x 450	220-260

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0x250	CBOH	150	1.4	W000287226
2.5x350	CBOX	210	4.1	W000258269
3.2x350	CBOX	130	4.3	W000258270
4.0x350	CBOX	90	4.5	W000258271
4.0x450	CBOX	90	5.7	W000258272
5.0x450	CBOX	55	5.4	W000258273

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.