

CITOFLEX M60A

The general purpose **metal cored wire** for M21 shielding gas.



OERLIKON

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CITOFLEX
EASY TO USE AND EXCELLENT OPERABILITY

CITOFLEX M60A

AWS 5.18: E70C-6M H4

EN ISO 17632-A: T 42 2 M M 1 H5



Advantages:

- High quality metal cored wire for welding with M21 gas
- Excellent arc stability and high deposition rate
- Regular welds with reduced amount of silicates
- Superior product consistency with optimal alloy control
- Suitable for single and multi-pass automatic welding
- Diffusible hydrogen below 4 ml/100g

Welding positions

(ISO/ASME)



PA/1G



PB/2F



PC/2G



PE/4G



PF/3Gu

Chemical composition, weld metal, M21 (wt. %):

C	Mn	Si	P	S
0,05	1,35	0,6	≤0,015	≤0,023

Mechanical properties, weld metal, AW, M21 gas:

Re (MPa)	Rm (MPa)	A (%)	CVN @-20°C (J)
>420	500-640	26	88

Packaging data

Packaging Type diam (mm)	B300 16 kg	Drum 200 kg
1,0	W000281040	
1,2	W000281042	W000281043
1,4	W000281044	
1,6	W000281046	