

# CITOFLEX M60

## TOP FEATURES

- CITOFLEX M60 is a high deposition rate metal cored wire with very good impact properties at -40°C. Better tolerance of variable gap and surface conditions in relation to MAG process
- Good side wall wetting, regular bead profile, optimized amount of silicates and reduced spatters
- Bridging and root passing capabilities with short and pulsed arc
- Very good weldability with short, pulsed and spray arc. Suitable for robotic applications
- Applicable for welding of flanges of wind mill towers.

## CLASSIFICATION

AWS A5.18	E70C-6M H4
EN ISO 17632-A	T 46 4 M M 1 H5
EN ISO 17632-B	T494T1-1MA-UH5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV/GL	TÜV	DB	CWB
+	+	+	+	+	+	+

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

C	Mn	Si	P	S
0.04	1.5	0.4	≤0.012	≤0.02

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	M21	AW	≥460	530-680	≥27	≥90

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281048
	DRUM	200.0	W000281049
1.4	DRUM	200.0	W000281051

### 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.