

CITORAIL

TOP FEATURES

- Weld Metal hardness ~275-325HB can be machined by chip-forming.
- Good weldability when positional welding
- Preferred to be used with DC+

CLASSIFICATION

EN 14700 E Fe1

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DB
+

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

C	Mn	Si	Cr	Fe
0.09	0.8	0.9	2.4	bal

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness (HB)
EN 14700	AW	150-450
Typical values	AW	275-325

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
4.0 x 450	140-180
5.0 x 450	190-240
6.0 x 450	210-280

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
4.0x450	CBOX	85	5.7	W000258525
5.0x450	CBOX	50	5.2	W000258526
6.0x450	CBOX	35	5.2	W000258527

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 for any updated information.