

CITOFIX

TOP FEATURES

- Suitable for welding on thin sheets.
- Smooth welds, self-releasing slag and good gap-bridging
- Very good weldability on AC and DC+ current.

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 38 A R 11

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All positions

APPROVALS

LR	BV	DNV
+	+	+

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

C	Mn	Si	P	S
0.09	0.5	0.4	≤0.03	≤0.03

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	not specified
Typical values	AW	470	560	22	65

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	50-70
2.5 x 300	60-85
3.2 x 350	100-125
3.2 x 450	85-135
4.0 x 350	130-170
4.0 x 450	115-180
5.0 x 350	160-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0x300	CBOX	325	3.6	W000258079
2.5x350	CBOH	130	2.4	W000386142
	CBOX	250	4.6	W000258080
3.2x350	CBOH	78	2.3	W000386143
	CBOX	170	5.0	W000258081
3.2x450	CBOX	145	5.8	W000258082
4.0x350	CBOH	58	2.5	W000386144
	CBOX	105	4.5	W000258083
4.0x450	CBOX	100	6.0	W000258084
5.0x450	CBOX	65	6.0	W000380847

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.