

CITOFIX is a rutile medium coated MMA electrode for a wide variety of mild steel fabrication applications. Suitable for welding on thin sheets. High performance general-performance rutile coated electrode for steelwork, workshop, shipbuilding and maintenance welding with easy operability. Smooth welds, self-releasing slag and good gap-bridging. Very good weldability on AC and DC+ current.

Classification	
EN ISO	2560-A: E 38 A R 11
AWS	A5.1: E 6013

Approvals	Grade
BV	2
DNV	2
LRS	2m



Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.09	0.50	0.40	≤ 0.03	≤ 0.03

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 380	470-600	≥ 20	≥ 47

Materials

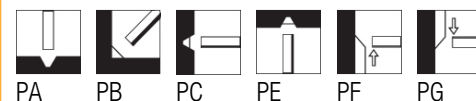
S(P)235 to S(P)355; GP240; GP280

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary 100°-110°C for 1 hour, max. 3 times.

Current condition and welding position

AC; DC-; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
2.0	300	50-70	11.80	161	W000380846		
2.5	350	60-85	18.74			250	W000258080
3.2	350	100-125	29.73			170	W000258081
3.2	450	85-135	43.70			135	W000378958
4.0	350	130-170	44.32			105	W000258083
4.0	450	115-180	60.0			95	W000378979
5.0	450	160-230	95.38			65	W000380847