

CITOFLEX H06

TOP FEATURES

- Metal cored gas shielded wire for hardfacing
- Can be used for hardfacing of wear parts, such as excavator components, scraper blades, dipper teeth, worm conveyors, beaters, crusher jaws, crusher cones, subjected to heavy wear
- The weld metal is tough, free of cracks and therefore resistant to shock and impact
- Machining is only possible by grinding

CLASSIFICATION

EN ISO 14700-A T Fe8

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO₂

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

C	Mn	Si	Cr
0.42	0.55	2.6	9.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Hardness (HRC)
Typical values	M21	AW	57-60

* AW = As welded

Gas test: 82% Ar + 18% CO₂

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281367
	DRUM	200.0	W000282367
1.6	SPOOL (B300)	16.0	W000281369

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.