

## Cored Wires C-Mn and low-alloy steels

CITOFLEX B13-0 is self shielded flux cored wire for welding in all positions. It is used for on-site assembly of sheet and plate metal or profile sections (thickness 3 to 15mm), for the spot welding of round bars for reinforced concrete and for joining galvanized parts.

### Classification

EN ISO	17632-A: T 42 Z Y 1 H15
AWS	A5.20: E71-T7

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Al
0.3	0.6	0.15	≤ 0.025	≤ 0.025	1.6

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 420	≥ 540	≥ 22	≥ 30

**Shielding Gas** - EN ISO 14175 : C1, M21

### Materials

S(P)235; GP240

Fe E215; Fe E235

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.2	●
1.6	●