

CITORAIL is a thick basic coated MMA electrode for hard facing deposits of medium hardness.

Surfacing of rails up to 855N/mm² Tensile Strength. Typical applications include rails, rail crossings, switch points, sprockets and wearing parts, such as rope pulleys, tumblers, rollers, caterpillar track rollers and links, wheel flanges, stud links and similar components.

Particularly suitable for hardfacing of wear-resisting parts subject to sliding impact e.g. slideways, shock resistance e.g. cams and rolling impact resistance e.g. rotors. Weld Metal hardness ~275-325HB can be machined by chip-forming. Good weldability when positional welding, the weld deposit is crack and porosity resistant. Shall be used in DC+ current.

Classification	
EN	14700: E Fe1
DIN	8555: E1-UM-300

Approvals	Grade
DB	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Fe
0.14	1.4	0.9	2.4	Rem

All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	275-325 HB

Materials

Electrode for surfacing rails up to 855 N/mm² tensile strength

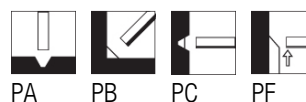
Storage

Keep dry and avoid condensation.

Re-drying recommended at 300-350°C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
3.2	450	110-130	44.7	140	W000258524
4.0	450	140-180	67.0	85	W000258525
5.0	450	190-240	104.0	50	W000258526
6.0	450	210-280	147.8	35	W000258527