

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

Citoflex R00 is a rutile flux cored wire with enhanced filling. The weld pool is easily controllable with outstanding welding properties. The enhanced filling results in increased current carrying capacity and hence deposition rate, thus increasing welding speed, leading to savings of time and costs. Low spatter loss and easy slag removal result in smooth and finely rippled welds without undercut.

Classification	
AWS	A5.20: E 71T-1 MJ
EN	758: T 42 3 P C 1 H5
EN	758: T 42 3 P M 1 H5

Approvals	Grades
ABS	
DNV	
LRS	
RINA	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.40	0.50	≤ 0.020	≤ 0.025	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -20° C	Hardness
As Welded	≥ 420	500-640	≥ 20	≥ 80	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21) or C1(Arcal 2)

### Materials

S(P)235-S(P)460, GP240-GP280

Shipbuilding steels A,B,D,E,AH32 to EH36

X42 to X70

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC +



**Packaging data:** K300 kg. 16

Diameters	1,0	1,2	1,6			