

Cored Wires C-Mn and low-alloy steels

Citoflex R 00 C 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 essentially 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 H4
EN	758: T 46 2 P C 1 H5

Approvals	Grades
DNV	
MMI	
RINA	

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	1.20	0.35	≤ 0.020	≤ 0.025	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -20° C	Hardness
As Welded	≥ 460	530-680	≥ 20	≥ 50	-

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: 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 +							
							
PA	PB	PC	PG	PF	PE	PG2	PF2

Packaging data: K300 kg, 16

Diameters	1,2					
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