

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

Citoflex R20 C is a rutile flux cored wire with a fast-freezing slag, and an easily controllable weld pool with outstanding welding properties in all positions. Low spatter loss, easy slag removal on ceramic backing or when joint filling, smooth and finely rippled welds without undercut. This cored wire has applications in shipyards, boiler (pressure water pipes), metallic framework and offshore.

Classification	
AWS	A5.29: E81T1-Ni1 H8
EN	T 46 5 Ni P C 1 H10

Approvals	Grades
ABS	
BV	
DB	
DNV	
LRS	
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
0.06	1.30	0.50	≤ 0.020	≤ 0.020	-	0.90	-	-	-	-	-

### 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) -50°C	Hardness
As Welded	≥ 460	530-680	≥ 20	≥ 47	-

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

### 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	1,0	1,2				
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