

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

Citoflex R 00 Ni is a rutile flux cored wire with enhanced filling and have a high deposition rate. Low spatter loss and easy slag removal result in smooth and finely rippled welds without undercut. It is suitable for all-positional welding with joint impact toughness values down to -40°C.

Classification	
AWS	A5.29: E 81T1-G
EN	758: T 46 4 1Ni PC 1 H5

Approvals	Grades
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
0.06	1.20	0.40	≤ 0.015	≤ 0.015	-	0.70	-	-	-	-	-

### 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) -40° C	Hardness
As Welded	≥ 460	530-680	≥ 20	≥ 80	-

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

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

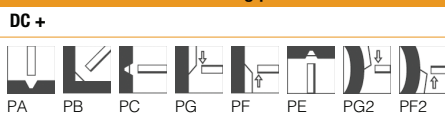
### Materials

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

### Storage

Keep dry and avoid condensation

### Current condition and welding position



**Packaging data:** K300 kg, 16

Diameters	1,2					
-----------	-----	--	--	--	--	--