

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

Citoflex R82 is a rutile flux cored wire with excellent all-positional weldability. Suitable for the welding of fine-grain structural steels for low temperature applications. Ideal for offshore and naval shipyard applications.

Classification	
AWS	A5.29: E 81T1 Ni M H4
EN	758: T 46 5 1Ni PM 1 H5

Approvals	Grades
DNV	

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
0.07	1.40	0.40	≤ 0.015	≤ 0.015	-	0.80	-	-	-	-	-

### 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	≥ 80	-

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

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

### 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 PF2

**Packaging data:** K300 kg. 16

Diameters	1,2					
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