

CITOFLEX R82 SR

Cored Wires C-Mn and low-alloy steels

Citoflex R82 SR is a rutile flux cored wire for all-positional welding with good impact toughness at -60°C (as welded and after PWHT). Very easy to use for vertical up welding. Suitable for the welding of fine-grain structural steels for low temperature applications. Ideal for offshore, naval shipbuilding, bridges and structures and pressure vessels applications. Good CTOD toughness.

| Classification | |
|----------------|--------------------------|
| AWS | A5.29: E81 T1 Ni1 M H4 |
| EN | 758: T 46 6 Ni1 P M 1 H5 |

| Approvals | Grades |
|-----------|--------|
| ABS | |
| DNV | |
| FI | |
| LRS | |
| RINA | |
| RS | |

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 | 1.35 | 0.30 | ≤ 0.015 | ≤ 0.015 | - | 0.80 | - | - | - | - | - |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) -60° C | Hardness |
|------------------|-------------------------------------|---------------------------------------|----------------------|--|----------|
| PWHT 580°C x 2 h | ≥ 460 | 530-680 | ≥ 20 | ≥ 47 | - |
| As Welded | ≥ 460 | 530-680 | ≥ 20 | ≥ 70 | - |

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 | | | | | |
|-----------|-----|--|--|--|--|--|