

# CITOFLEX R07

## Cored Wires High-strength steels

Citoflex R07 is a rutile flux cored wire suitable for welding high strength fine-grain structural steels. Low spatter, easy slag removal and regular bead appearance.

Classification	
AWS	A5.29: E 111 T1-G H4
EN	12535: T 69 5 Mn2,5Ni P 1 H5

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.40	0.40	≤ 0.015	≤ 0.015	-	2.50	-	-	-	-	-

### 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	≥ 690	770-940	≥ 17	≥ 47	-

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

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

### Materials

S620, S690, HY 100

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC +



**Packaging data:** K300 kg. 16

Diameters	1,2					
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