CITOFLUX R111

MIG/MAG Cored Wires
C-Mn and low-alloy steels

CITOFLUX R111 is a T 42 2 1Ni R C 3 H5 / T 42 2 1Ni R M 3 H10 folded type MAG rutile flux cored wire, depositing C-0.8Mn0.8Ni weld metal. Suitable for welding with CO2 and Ar-CO2 mixed shielding gases.
CITOFLUX R111 is designed for welding single and multi-layer butt, negligible spatter loss, easy slag removal, smooth, finely rippled weld beads without undercutting into the base metal.
CITOFLUX R111 with a slow–freezing slag and outstanding welding properties in downhand and fillet positions has an excellent weld appearance to improve fatigue resistance. Typical application is the heavy transport vehicles and road construction machinery.

Classification	
EN ISO	17632-A: T 42 2 1Ni R C 3 H5
EN ISO	17632-A: T 42 2 1Ni R M 3 H10
AWS	A5.36: E70T1-C1A2-K6-H4
AWS	A5.36: E70T1-M21A0-K6-H8

Chemical analysis (Typical values in %)

C	Mn	Si	Ni
0.04	0.8	0.4	0.8

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-30 °C
As Welded (*)	≥ 420	500-620	≥ 23	≥ 70	
As Welded (**)	≥ 420	500-620	≥ 23	≥ 80	≥ 60

Gas test: (*) 82% Ar+18% CO2, (**) 100% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

S(P)235-S(P)420, GP240-GP280

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+

PA PB