## 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	trength Tensile Strength		Impact Energy ISO - V (J)	
neat freatilient	(MPa)	(MPa)	A5 (%)	-20 °C	-30 °C
As Welded (*)	≥ 420	500-620	≥ 23	≥ 70	
As Welded (**)	≥ 420	500-620	≥ 23	≥ 80	≥ 60

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

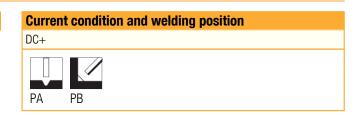
**Shielding Gas -** EN ISO 14175 : C1, M21

#### **Materials**

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

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J	LU	па	ч	G

Keep dry and avoid condensation



Rev: 2019-04-16