CITOFLUX R00

FCAW/MCAW Cored Wires
C-Mn and low-alloy steels

CITOFLUX R00 is rutile flux-cored wire for gas-shielded metal arc welding of unalloyed steels for operating temperatures from -30°C up to +450°C in all welding positions. The weld pool is easily controllable with outstanding welding properties. The enhanced filling results in increased current carrying capacity and hence deposition rate, thus essentially increasing welding speed, leading to savings of time and costs. Low spatter loss and easy slag removal result in smooth and finely rippled welds without undercut. Can be used in manual and fully-mechanised processes, very well suited for use on ceramic backing. Preferably used under mixed gas. The use of CO2 is possible.

Classification	
EN ISO	17632-A: T 42 2 P C 1 H5
EN ISO	17632-A: T 42 3 P M 1 H5
EN ISO	17632-B: T492T1-1CA-UH5
EN ISO	17632-B: T493T1-1MA-UH5
AWS	A5.20: E71T-1C-H4
AWS	A5.20: E71T-1M-JH4

Approvals	Grade
ABS	3Y400SA,3YSA H5
BV	SA3Y40M,SA3YM H5
CRS	3YH5S
DNVGL	III Y40MS,3Y40 H5
LRS	3Y40S,3YS H5
PRS	3Y40S,3YS H5
RINA	3Y40S,3YS H5
RMRS	3Y40MS,3YS H5

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.47	0.5	≤0.015	≤0.015

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	min 420	500-640	≥ 26	≥ 80	≥ 50

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

Shipbuilding steels A,B,D,E,AH32 - EH36

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

X42 - X65

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.0	W000281145
1.2	W000281147