

CITOFLUX R00 Ni is folded rutile flux-cored wire for gas-shielded metal arc welding of unalloyed steels for operating temperatures from -40°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.

Rutile strip flux cored wire used in all positions for highly stressed welds in shipyards and mechanical structures. Excellent mechanical characteristics with resilience at -40°C.

Classification		Approvals	Grade
EN ISO	17632-A: T 46 4 1Ni P C 1 H5	ABS	4Y400SAH5
EN ISO	17632-A: T 46 4 1Ni P M 1 H5	BV	SA3YMH5
EN ISO	17632-B: T554T1-1CA-N1-UH5	DB	●
EN ISO	17632-B: T554T1-1MA-N1-UH5	DNV	IV Y40MS H5
AWS	A5.29: E81T1-GC-H4	LRS	4Y40 H5
AWS	A5.29: E81T1-GM-H4	RINA	4Y40SH5
AWS	A5.36: E81T1-C1A4-G-H4		
AWS	A5.36: E81T1-M21A4-G-H4		

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.06	1.2	0.4	≤ 0.015	≤ 0.015	0.7

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
As Welded (*)	≥ 460	570-680	≥ 24	≥ 80
As Welded (**)	≥ 460	550-590	≥ 23	≥ 47

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

Shielding Gas - EN ISO 14175 : C1, M21

Materials

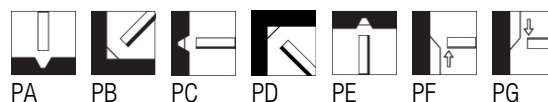
S(P)235-S(P)460, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



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

Packaging data

Packaging Type	B300	S200
Diam(mm) / weight(kg)	16	5
1.2	W000281150	W000281149