CITOFLUX R00C

TOP FEATURES

- The optimized fill ratio results in increased deposition rate and productivity leading to savings in total welding cost.
- The weld pool is easily controllable in positional welding with outstanding arc properties and quality levels.
- Low spatter and easy slag removal result in smooth and regular welds.
- Can be used in semiautomatic and mechanized processes, very well suited for use on ceramic backing.

CLASSIFICATION

AWS A5.20	E71T-1C-JH4
	E71T-1M-JH4
EN ISO 17632-A	T 42 3 P C 1 H5
	T 42 3 P C1 1 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO_2
M21	Mixed gas Ar+ >15-25% CO_2

APPROVALS

LRS	PRS	RINA	RMRS	CE
3YSH5 (C1)	3Y40SH5 (C1)	3Y40SMH5 (M21)	3Y40SMH5 (M21)	+
	3YSH5 (C1)	3YSH5 (C1)	3YSH5 (C1)	

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.05	1.3	0.4	≤0.015	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-20°C	-30°C
Typical values	M21	AW	min 460	530-680	≥26	≥80	
	C1	AW	min 420	500-640	≥25		≥70

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000382937

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.