CITOFLUX R550

TOP FEATURES

- CITOFLUX R550 is E91 rutile cored wire for positional welding of high-strength steels with minimum yield strength of 550 MPa and -50°C impact.
- Rutile flux cored very good positional weldability. Very good slag removal, regular high quality welds.
- Applicable both for semiautomatic and mechanised welding.
- Ideal for offshore, wind tower foundations and structural applications.

CLASSIFICATION

| AWS A5.29 | E91T1-G M H4 |
| EN ISO 18276-A | T55 5 Mn1,5Ni P M21 1 H5 |

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

| M21 | Mixed gas Ar+ >15-25% CO_2 |

APPROVALS

DNV
+

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

C	Mn	Si	P	S	Ni
0.07	1.3	0.4	≤0.015	≤0.015	1.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	M21	AW	≥550	620-760	≥20	≥47

* AW = As welded

Gas test: 82% Ar + 18% CO_2

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000275204

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:

CITOFLUX R550-EN-23/10/23

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