CITOFLUX R82

TOP FEATURES

- Rutile 0.9%Ni flux cored wire with excellent all-positional weldability and good impact toughness at -50°C.
- Best in class welding performance and productivity in positional welding.
- Optimal solution for welding of wind mill foundations, offshore and steel constructions.
- Can be applied for applications requiring CTOD testing.

CLASSIFICATION

AWS A5.29	E81T1-Ni1M-H4
EN ISO 17632-A	T 46 5 1Ni P M21 1 H5
EN ISO 17632-B	T555T1-1M21 A-N1-UH5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ >15-25% CO_2

APPROVALS

ABS	LR	DNV
+	+	+

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

C	Mn	Si	P	S	Ni
0.05	1.3	0.4	≤0.010	≤0.010	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-40°C	-50°C
Typical values	M21	AW	≥460	550-690	≥22	≥80	≥60

* 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	W000281158

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.