

CITOFLEX R82 SR

TOP FEATURES

- CITOFLEX R82SR is a folded rutile flux cored wire for all-positional welding with good impact toughness at -50°C (as welded and after PWHT)
- Best in class welding performance in positional welding.
- Optimal solutions for wind mill, oil and gas, structural and pipeline applications.
- Very stable impact properties.
- 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% CO₂

APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

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

C	Mn	Si	P	S	Ni
0.05	1.4	0.2	≤0.015	≤0.015	0.95

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	min 470	550-690	≥24	≥60
	M21	600°C / 1h	min 470	550-690	≥25	≥70

* AW = As welded

Gas test: 82% Ar + 18% CO₂

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281161

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.