CITOFLUX R82 SR



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

CITOFLUX R82SR is a folded rutile flux cored wire for all-positional welding with good iMPact toughness at -60°C (as welded and after PWHT). Very easy to use for vertical up welding. Suitable for the welding of fine-grain structural steels for low temperature applications. Can be welded in all positions with one setting of parameters. To be use under mix gas. Ideal for offshore, naval shipbuilding, bridges and structures and pressure vessel applications. Good CTOD toughness.

| Classification | | |
|----------------|------------------------------|--|
| EN ISO | 17632-A: T 46 6 1Ni P M 1 H5 | |
| EN ISO | 17632-B: T556T1-1MA-N1-UH5 | |
| AWS | A5.29: E81T1-Ni1M-H4 | |

| Approvals | Grade |
|-----------|------------|
| ABS | 4Y400SA H5 |
| DNV | VY46MS H5 |
| LRS | 4Y40S H5 |

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Chemical analysis (Typical values in %)

| C | Mn | Si | Р | S | Ni |
|------|------|-----|---------|---------|-----|
| 0.07 | 1.35 | 0.3 | ≤ 0.015 | ≤ 0.015 | 0.8 |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength (MPa) | Tensile Strength (MPa) | Elongation A5 (%) | Impact Energy ISO - V (J) -60 °C |
|----------------|-------------------------|------------------------|----------------------|-------------------------------------|
| As Welded | ≥ 460 | 530-680 | ≥ 22 | ≥ 47 |
| 580 °C /2h | ≥ 460 | 530-680 | ≥ 22 | ≥ 47 |

Gas test: 82% Ar+18% CO2

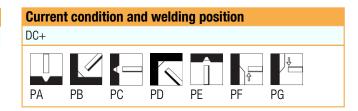
Shielding Gas - EN ISO 14175: M21

Materials

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

Storage

Keep dry and avoid condensation



Packaging data

| Packaging Type | B300 |
|-----------------------|------|
| Diam(mm) / weight(kg) | 16 |
| 1.2 | • |

