

## 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

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	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

Current condition and welding position						
DC+						
						
PA	PB	PC	PD	PE	PF	PG

### Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.2	●