

CITOFLUX R550 is rutile cored wire for the welding of high-strength fine grain structural steels with minimum yield strength of 550 MPa. Very good slag removal, smooth seam surface without undercutting into the base metal. Can be used in manual and fully-mechanised processes for example with orbital or vertical guiding device. Can be welded in all positions with one setting of parameters! Used under mixed gas as shielding gas only.

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

Approvals	Grade
DNV	VY55MS H5

CE

### Chemical analysis (Typical values in %)

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

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-50 °C
As Welded	≥ 550	620-760	≥ 20	≥ 47


Gas test: 82% Ar+18% CO2

**Shielding Gas** - EN ISO 14175 : M21

### Materials

S(P)460, S(P)500, S550, HY 80

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	●