

CITOFLEX R620 is a rutile flux cored wire with excellent all-positional weldability. Suitable for welding of high-strength fine grain structural steels with minimum yield strength of 620 MPa. Low spatter with easy slag removal and regular bead appearance. Ideal for offshore and naval shipyard applications. Adapted for high heat input procedures. Exceptional weldability in particular for pipe welding in vertical up position.

Classification

EN ISO	18276-A: T 62 4 1NiMo P M 1 H5
EN ISO	18276-B: T695T1-1MA-N2M2-H5
AWS	A5.29: E91T1-G H4

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.07	1.40	0.40	≤ 0.015	≤ 0.015	0.9	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
As Welded	≥ 620	700-800	≥ 20	≥ 47

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

S(P)460-S(P)620

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300	S200
Diam(mm) / weight(kg)	16.0	5.0
1.2	●	●