## CITOFLUX R620



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# MIG/MAG Cored Wires High-strength steels

CITOFLUX 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	Р	S	Ni	Мо
0.07	1.40	0.40	≤ 0.015	≤ 0.015	0.9	0.4

#### **All-weld metal Mechanical Properties**

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

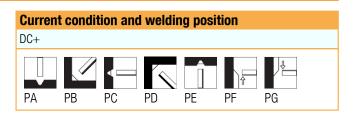
Gas test: 82% Ar+18% CO2

### Shielding Gas - EN ISO 14175: M21

#### **Materials**

S(P)460-S(P)620

S	Storage		
K	Geep dry and avoid condesation		



### **Packaging data**

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

