CITOFLUX R71

FCAW/MCAW Cored Wires
C-Mn and low-alloy steels

CITOFLUX R71 is quality rutile flux-cored wire for gas-shielded metal arc welding of unalloyed steels in all welding positions. Thanks to an innovative flux formulation,the weld pool is easily controllable with outstanding welding properties and optimized wettability. The enhanced filling results in increased current carrying capacity and augmented deposition rate. Higher welding speed allows savings in time and costs. Characterized by very low spatter presence and easy slag removal the bead is smooth and finely rippled without undercut. Low fume emission rate, deep penetration and outstanding weldability make this wire an ideal solution for shipbuilding applications. It can be used in manual and fully-mechanised processes, very well suited for use on ceramic backing and with long liner. It can be used under CO2.

Classification	
EN ISO	17632-A: T 42 2 P C 1 H10
EN ISO	17632-A: T 46 2 P M 1 H10
AWS	A5.20: E71T1-1/9C H8

Approvals	Grade
ABS	3Y400SA H5 (M21)
ABS	3YSA H5 (C1)
BV	SA3YM H5 (C1)
BV	SAY40M H5 (M21)
CRS	3YH5 H5 (C1)
DNVGL	3Y40 (C1)
DNVGL	3Y40MS H5 (M21)
LRS	3Y40S H5 (M21)

Approvals	Grade
LRS	3YS (C1)
PRS	3Y40S (M21)
PRS	3YS H5 (C1)
RINA	3Y40S (M21)
RINA	3YS H5 (C1)
RMRS	3Y40MS (M21)
RMRS	3YS H5 (C1)

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.3	0.40	≤0.015	≤0.015

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)
				-20 °C
As Welded	≥ 530	≥ 590	25	> 47

Gas test: CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

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

Shipbuilding steels A,B,D,E,AH32 - EH36

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.2	W000386374