

# CITOFLEX R00Ni

## TOP FEATURES

- CITOFLEX R00Ni is rutile flux cored delivering good impact properties at -40°C. Ni alloyed, for welding with mix gas.
- The optimized fill ratio results in increased deposition rate and productivity leading to savings in total welding cost.
- At least two times higher productivity comparing to basic manual electrode in positional welding.
- Can be used in semiautomatic and mechanized processes, very well suited for use on ceramic backing.
- The weld pool is easily controllable in positional welding with outstanding arc properties and quality levels.
- Low spatter and easy slag removal result in smooth and regular welds.

## CLASSIFICATION

AWS A5.29	E81T1-GM-H4
EN ISO 17632-A	T 46 4 1Ni P M21 1 H5
EN ISO 17632-B	T554T1-1M21A-N1-UH5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO<sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV	DB
+	+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni
0.06	1.2	0.4	≤0.015	≤0.015	0.7

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	M21**	AW	≥460	570-680	≥24	≥80

\* AW = As welded

\*\* Gas test: 82% Ar + 18% CO<sub>2</sub>

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281150
	SPOOL (B5300)	16.0	W000403658

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.