

# CITOFLEX ROONiC

## TOP FEATURES

- CITOFLEX ROONiC is folded rutile flux cored for CO<sub>2</sub> shielding gas wire with impact properties tested at -40°C.
- High productivity, especially in positional welding, leading to savings in total welding cost.
- Low spatter and easy slag removal result in smooth and regular welds.
- Can be used in semiautomatic and mechanized processes, very well suited for use on ceramic backing.
- Can be used for PWHT applications.

## CLASSIFICATION

AWS A5.20 E71T-1C-JH4  
 EN ISO 17632-A T 46 4 P C1 1 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO<sub>2</sub>

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

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

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	C1	AW	≥460	510-610	≥24	≥80
	C1	580°C x 2h/f.	≥460	510-610	≥24	≥80

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	16.0	W000375124

### 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.