



OERLIKON

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CITOFLOW
THE OERLIKON FLUX AND METAL CORED WIRES

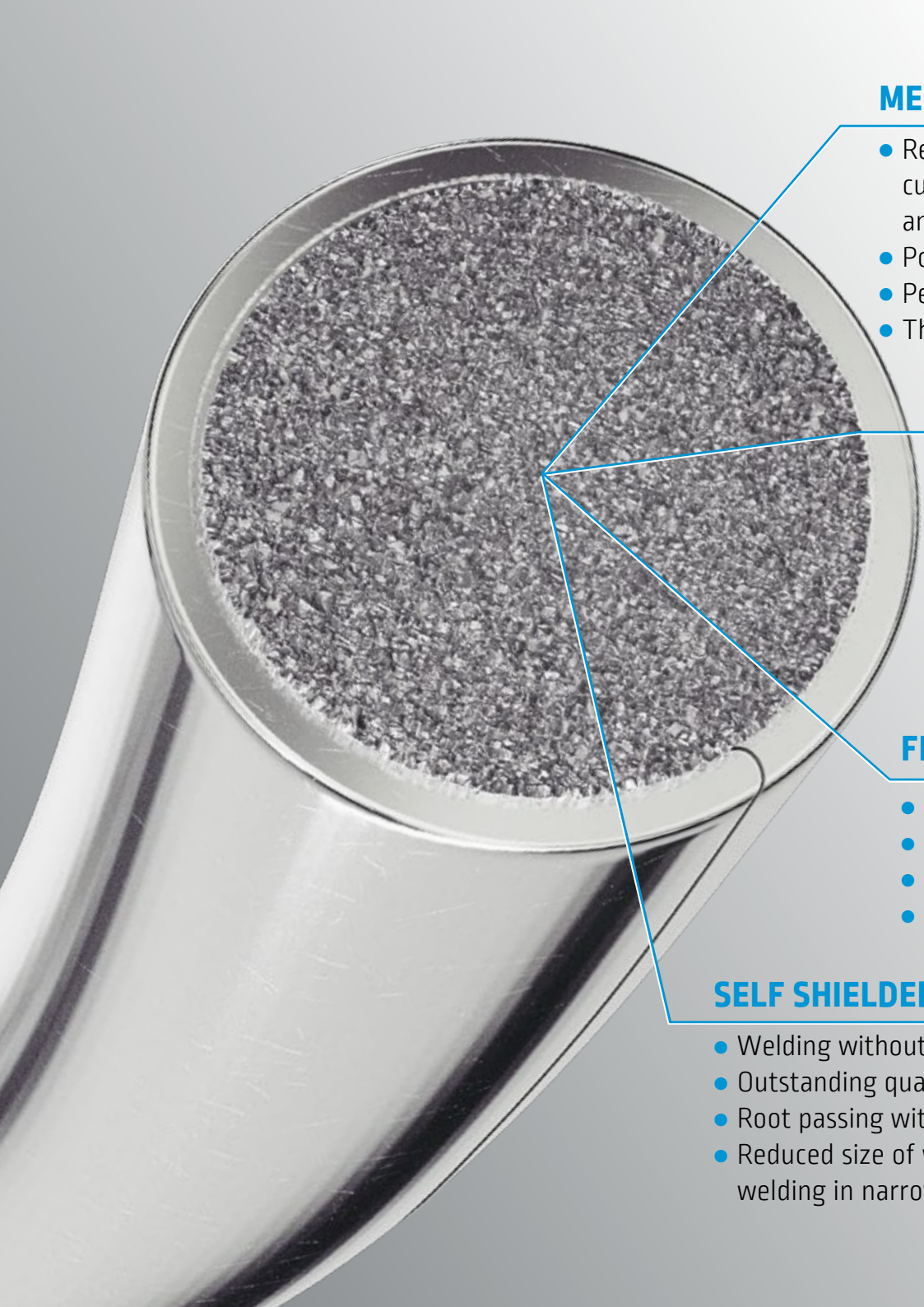
CITOFLEX THE OERLIKON CORED WIRE

Citoflux flux and cored wires meet the highest industry weldability and reliability expectations through best in class manufacturing metal process, verified properties, metallurgy and responsible quality control process.



- Guaranteed diffusible hydrogen content.
- The highest deposition rate driven by optimal current density.
- Very consistent chemical composition.
- Well balanced yield and tensile strength.
- Impact down to -60°C .
- Consumable and blend homogeneity.





METAL CORED [138]

- Reduced welding cost in downhand positions cause of increased productivity, current density, superior quality of welds, tolerance of surface contamination, and easier welding combined reduced welders' training time.
- Positional and root passing capability with short and pulsed arc.
- Perfect for robotic and mechanized applications, regular slag free welds.
- The latest grades offer reduced welders' exposure to welding fumes.

FLUX CORED RUTILE [136]

- Reduced welding cost in positional welding cause of high current density, quality of welds, tolerance of surface contamination, and easier welding combined with reduced welders' training time.
- The best solution for vertical up, slag supports the welding pool.
- Root passing with the ceramic backing.
- Suitable for robotic and mechanized applications, regular welds and self peeling slag.

FLUX CORED BASIC [136]

- Superior mechanical properties cause of basic slag system.
- Root passing without or with ceramic backing
- All positional welding capability.
- Slag support when welding vertical up.

SELF SHIELDED [114]

- Welding without shielding gas, outdoor applications
- Outstanding quality of welds in challenging environmental conditions.
- Root passing without and with ceramic backing.
- Reduced size of welding torch and long ESO enhance welding in narrow groves.

Technical data

| Product name | | Type | Gas | AWS 5.36 | EN ISO 17632-A/18276-A /17634-A |
|-------------------------------------------------------------------------------|-------------------------|------|--------|--------------------------------------------|---------------------------------------------|
| Mild Steels 275MPa<Re<460Mpa | | | | | |
| CITOFLEX R00 | | R | M21/C1 | E71T1-M21A2-CS1-H4 E71T1-C1A0-CS1-H4 | T 42 3 P M 1 H5 T 42 2 P C 1 H5 |
| CITOFLEX R00C | | R | C1/M21 | E71T1-C1A2-CS1-H4 | T 46 3 P C 1 H5 |
| CITOFLEX R111 | | R | M21/C1 | E70T1-M21A0-K6-H8 E70T1-C1A2-K6-H4 | T 42 2 1Ni R M 3 H10 T 42 2 1Ni R C 3 H5 |
| CITOFLEX R71 | | R | M21/C1 | E71T1-M1A2-MS1 H8 E71T1-C1A2-CS1 H8 | T 46 2 P M 1 H10 T 42 2 P C 1 H10 |
| CITOFLEX M60A | | MC | M21 | E71T15-M21A2-CS1-H4 | T 42 2 M M 1 H5 |
| CRISTAL F206 | Reduced fume | MC | M21/14 | E71T15-M21A2-CS1-H4 E70T15-M14A2-CS1-H4 | T 42 3 M M 1 H5 |
| CITOFLEX B13-0 | Self-shielded | N/A | M21 | E71T7-AZ-G-H16 | T 42 Z Y 1 H15 |
| CITOFLEX GALVA | For Zn coat. | N/A | M21 | E60G-M21G-GS-H16 | T3T Z M M 1 H15 |
| High Strength Steels 355MPa<Re<550MPa, impact at -40°C and -60°C | | | | | |
| CITOFLEX M60 | Impact at -40°C | MC | M21 | E71T15-M21A4-CS1-H4 | T 46 4 M M 1 H5 |
| CITOFLEX M00 | Impact at -50°C | MC | M21 | E71T15-M21A6-CS1-H4 | T 46 5 M M 1 H5 |
| CITOFLEX M20 | Impact at -60°C | MC | M21 | E71T15-M21A8-G-H4 | T 46 6 Mn1Ni M M 1 H5 |
| CITOFLEX B00 | Impact at -50°C | B | M21/C1 | E70T5-M21A8-CS1-H4, E70T5-M21A8-CS1-H4 | T 42 5 B M 2 H5 T 42 5 B C 2 H5 |
| CITOFLEX R00Ni | Impact at -40°C | R | M21/C1 | E81T1-M21A4-G-H4 E81T1-C1A4-G-H4 | T 46 4 1Ni P M 1 H5 T 46 4 1Ni P C 1 H5 |
| CITOFLEX R00NIC | Impact at -40°C | R | C1 | E81T1-C1A4-CS1-H4 | T 46 4 P C 1 H5 |
| CITOFLEX R82 | Impact at -50°C | R | M21 | E81T1-M21A6-Ni1-H4 | T 46 5 1Ni P M 1 H5 |
| CITOFLEX R82 SR | Impact at -60°C PWHT | R | M21 | E81T1-M21P8-Ni1-H4 | T 46 6 1Ni P M 1 H5 |
| CITOFLEX R83 | Impact at -60°C | R | M21 | E81T1-M21G-Ni1-H4 | T 46 6 1Ni P M 1 H5 |
| CITOFLEX R83C | Impact at -60°C | R | C1 | E81T1-M21P8-Ni1-H4 | T 46 6 1Ni P C 1 H5 |
| CITOFLEX R550 | Re 550MPa | R | M21 | E81T1-M21G-Ni1-H4 | T55 5 Mn1, 5Ni P M 1 H5 |
| Hardfacing | | | | | |
| CITOFLEX H06 | 57-60HRC | | M21 | | EN 14700: T Fe8 |

R: Rutile; B: Basic; MC: Metal Cored

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