

CITOFLEX R83 C

TOP FEATURES

- CITOFLEX R83C is best in class rutile flux cored wire with excellent positional weldability and good impact toughness down to -60°C.
- Best in class welding performance and productivity in positional welding.
- Ideal for wind mill foundations, offshore and structural applications.
- Meets NACE MR-0175 requirements.

CLASSIFICATION

AWS A5.29 E81T1-Ni1C
 EN ISO 17632-A T 46 6 1Ni P C1 1 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO₂

APPROVALS

| ABS | DNV |
|-----|-----|
| + | + |

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

| C | Mn | Si | P | S | Ni |
|------|-----|-----|--------|--------|------|
| 0.05 | 1.2 | 0.4 | ≤0.014 | ≤0.014 | 0.85 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Shielding gas | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) | |
|----------------|---------------|---------------|----------------------|------------------------|----------------|------------------|---------|
| | | | | | | -40°C | -60°C |
| Typical values | C1 | AW | min. 470 | 550-690 | min. 20 | | min. 47 |
| | C1 | PWHT 620°C/2h | min. 470 | 550-690 | min. 20 | min. 47 | |

* AW = As welded

PACKAGING AND AVAILABLE SIZES

| Wire diameter (mm) | Packaging | Weight (kg) | Item number |
|--------------------|--------------|-------------|-------------|
| 1.2 | SPOOL (B300) | 16.0 | W000383908 |

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 for any updated information.