

CITOFLEX ROOC

Rutile Flux Cored Wire for welding of unalloyed steels with C1 and M21 shielding gases.



OERLIKON

www.oerlikon-welding.com

CITOFLEX
EASY TO USE AND EXCELLENT OPERABILITY

CITOFLEX ROOC

AWS A5.20: E71T-1/9C-H4, E71T-1/9M-H4

EN ISO 17632-A:T 42 3 P C 1 H5/T 46 2 P M 2 H5



Advantages:

- Outstanding welding properties and easily controllable weld pool
- Developed for welding with C1 and optimized for Ar/CO2 mix gas; smooth arc with low spatter
- Excellent operator appeal due to superior welding characteristics and premium slag system
- Full out-of-position capability and increased deposition rates
- H4 class in 1,6 mm diameter
- ABS, DNV-GL, LRS, BV, RINA, RMRS approved

Welding positions

(ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G

Chemical composition, weld metal (wt. %):

Gas	C	Mn	Si	P	S
C1	0,05	1,3	0,4	0,015	0,009
M21	0,05	1,5	0,5	0,015	0,009

Mechanical properties, weld metal, AW:

Gas	Re (MPa)	Rm (MPa)	A (%)	Impact @-20°C (J)	Impact @-30°C (J)
C1	min. 420	500-640	25		70
M21	min. 460	530-680	26	80	

Ordering information

Item # by most popular customer' choice:

Item #	Ø (mm)	Coil	Weight (kg)
W000382937	1.2	B300	16
W000281144	1.6	B300	16