

A rutile coated general-purpose electrode for MMAW



Classification AWS A5.1: E 6013
IS: 814 ER 4212X

DESCRIPTION

ESAB 28 is a medium heavy rutile coated mild steel electrode designed for welding of unalloyed structural steels in all positions. The electrode gives smooth radiographic quality weld with low spatter and smoke. Bead shape is smooth and slag is easy to remove.

APPROVALS

ABS Gr.2, BIS, BV Gr.2, CIB, DNV Gr.2, EIL, IRS Gr.2, LRS Gr.2, MMD, PDIL, RDSO C2.

WELDING CURRENT: DC (-), AC 50V

TYPICAL APPLICATIONS

It is recommended for welding structures of varying thicknesses of MS plates in different type of joints and welding ordinary grade ship steel as well as structural steel of similar strength and composition. Suitable for welding of pipes, bridges, boilers and pressure vessels etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.09	Mn	0.45	YS	420 N/mm ²
Si	0.24	S	0.02	UTS	500 N/mm ²
P	0.02			EL (L=5d)	26%
				Impact (CVN) at 0°C	80J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.00	300	45-60	250	1000
2.50	350	60-85	190	760
3.15	350	85-120	120	480
3.15	450	85-120	120	480
4.00	350	120-175	75	300
4.00	450	120-160	75	300
5.00	450	160-240	50	200
6.30	450	230-300	30	120

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.