

ESAB 28



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. Slag is self detachable and the bead shape is uniform and finely rippled.

Specifications	
Classifications	SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 38 0 RC 11 IS 814 : ERR4212X
Approvals	ABS : 2 BIS : ERR4212X BV : 2 CE : EN 13479 DNV : 2 IBR : E6013 IRS : 2 LR : 2 NAKS/HAKC : 2.5-4.0mm PDIL : E6013

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	C-Mn
Coating Type	Rutile
Min AC OCV	50

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	420 MPa	510 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	0 °C	90 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	0.35	0.25

Deposition Data	
Diameter	Current
2.5 x 350 mm	50-80 A
3.15 x 350 mm	70-120 A
3.15 x 450 mm	70-120 A
4.0 x 450 mm	100-170 A
5.0 x 450 mm	150-260 A