



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

<b>Classifications:</b>	SFA/AWS A5.1:E6013, EN ISO 2560-A:E 38 0 RC 11, IS 814:ER4212X
<b>Approvals:</b>	ABS 2, BV 2, DNV 2, IBR E6013, IRS 2, LR 2m, PDIL E6013

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

<b>Welding Current:</b>	AC, DC+-
<b>Alloy Type:</b>	C-Mn
<b>Coating Type:</b>	Rutile

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	420 MPa	510 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	0 °C	90 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.08	0.35	0.25

### Current Range

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