

## 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	
<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 CE : EN 13479 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

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	50-80 A
3.15 x 350.0 mm	70-120 A
3.15 x 450.0 mm	70-120 A
4.0 x 450.0 mm	100-170 A
5.0 x 450.0 mm	150-260 A