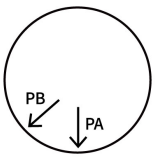
S-7028.F

Classification

AWS A5.1/ASME SFA-5.1 E7028
JIS Z 3211 E4928
EN ISO 2560-A E42 2 B 7 4
KS D7006 E5026

Welding Positions





Features

- Heavy iron powder type electrode
- High deposition rate
- Easy to remove slag

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.28	0.98	0.028	0.007

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
449(65)	527(76)	24	-20(0)	48(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
4.0(5/32)	550(22)	150-220	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.5(11/64)	550(22)/700(28)	170-220	
5.0(3/16)	700(28)	190-250	
5.5(7/32)	700(28)	220-270	
6.0(15/64)	700(28)	250-320	
6.4(1/4)	700(28)	270-340	
7.0(9/32)	700(28)	300- 360	