

ES 7028

Type Rutile-basic

SMAW

E7028

ESWECO
The Art of Welding

Description

ES 7028 is a high-recovery, iron powder, LMA electrode, which gives extremely smooth fillets of equal leg length and very low emissions of fume and spatter. It is very easy to weld and is especially suitable for horizontal fillets with a leg length of 4-6.4 mm. ES 7028 is as easy to use as a rutile electrode, but the weld metal quality corresponds to that of basic electrodes. The slag is easy to remove.

Recovery

150%

Current

AC, DC+ - OCV 60 V



Classifications

SFA/AWS A5.1	E7028
EN 499	E 42 3 RB 53 H10
ISO 2560	E51 4B 150 36H

Typical all weld metal composition, %

C	Si	Mn
0.07	0.5	1.1

Typical mech. Properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	515
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
-20	110
-40	90

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	450	130-150	24
4.0	450	150-220	28
5.0	450	220-320	32