

S-7028.F

Type : High recovery Basic

Conformances

AWS	A5.1/ ASME SFA5.1 E7028
JIS	Z3211 E4928
EN	ISO 2560-A-E42 2 B 7 4
KR	3Y
ABS	3, 3Y
LR	3YG
BV	3, 3Y
DNV-GL	3 (25 t)
NK	KMW3, KMW53

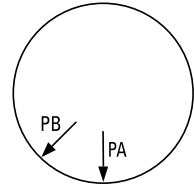
Applications

- Heavy steel fabrication

Features

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

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
4.0 (5/32)	550 (22)		✓
4.5 (11/64)	550 (22)		✓
4.5 (11/64)	700 (28)		✓
5.5 (7/32)	700 (28)		✓
6.0 (15/64)	700 (28)		✓
6.4 (1/4)	700 (28)		✓
7.0 (9/32)	700 (28)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.29	1.08	0.027	0.015

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
478 (69,400)	546 (79,300)	32.0	-20 (-4)	63 (47)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	4.0 (5/32)	4.5 (11/64)	5.0 (3/16)	5.5 (7/32)	6.0 (15/64)	6.4 (1/4)	7.0 (9/32)
Length mm (in)	550 (22)	550 (22) 700 (28)	700 (28)	700 (28)	700 (28)	700 (28)	700 (28)
F	150-220	170-220	190-250	220-280	260-320	270-340	330-360

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX