

CEWELD E 7028

TYPE High recovery (180%) basic electrode

APPLICATIONS High efficiency heavy coated basic type electrode Suitable for medium section steel fabrication, tanks building, shipyards and in general where a high speed welding is required.

PROPERTIES Suitable for downhand butt- and fillet weld, smooth welding pool without spatter loss, easy slag release, very nice bead surface

CLASSIFICATION

AWS	A 5.1: E 7028
EN ISO	2560-A: E 42 2 B 83
F-nr	1
FM	1


SUITABLE FOR **Rp < 420 MPa (60ksi) ISO 15608: 1.1** ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)

1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932

10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,
 S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M,
 P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240,
 A, B, D, E, A 32-E 36
 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, Domex 315-420MC, MC Plus, ML

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn
0.07	0.5	1.2

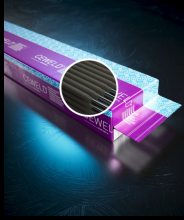
MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	
				-20°C	Hardness
As Welded	430	530	26	60	HRc

REDRYING 300°C / 2 hr

CURRENT TYPE: DC+

GAS ACC. EN ISO 14175



CEWELD E 7028

E 7028 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,2	8720682050828

E 7028 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682050835

E 7028 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,3	8720682050842