



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