

Applications

S-7028.F can be used for highly efficient-welding of flat and horizontal fillet such as welding of high tensile steel of ships, bridges and building.

Characteristics on Usage

S-7028.F is a heavy iron powder type electrode.

This electrode is intended for applications requiring the characteristics of the high deposition rate associated with iron-powder coating.

Notes on Usage

- ① Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ② Remove rust, water and oil from the surface to be welded before welding.

Welding Position



1G 2F
(PA) (PB)

Current

AC or DC +

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)

Approval

KR, ABS, LR, BV, DNV, GL, NK

I Packing

Packet 10 kg (22 lbs)
Carton 10 kg (22 lbs) × 2 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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