

PRODUCT DATA SHEET

GENERAL PURPOSE ELECTRODES

PH28



SUMMARY

- > General purpose rutile type electrode
- > Fairly rapid solidifying slag
- > Very good weld appearance for all positions
- > Excellent X-Ray properties

IDENTIFICATION

Coating - Tan **Tip** - Blue **Imprint** - PH28 6013 4313A

CLASSIFICATION

- > AS/NZS 4855B E4313A
- > AWS A5.1 E6013

DESCRIPTION AND APPLICATION

The Weldwell PH28 electrode has a medium-heavy rutile coating and yields a fairly rapidly solidifying slag. The weld appearance is very good for all positions. It is very easy to apply in the vertical up and overhead positions where a short arc length is beneficial.

The PH28 has excellent X-Ray properties.

It's a very easy electrode to use, even less experienced welding operators will obtain good results.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
2.5	305	70 - 100
3.2	380	85 - 135
4.0	380	130 - 170

*Recommended for DC- or AC (minimum 50 OCV).
Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

- > **Lloyd's Grading** - DXVuo BF 2m NR
- > **BV Grade** - 2
- > **ABS Grade** - 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si
0.04	0.47	0.40

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	448 MPa
Tensile Strength	500 MPa
Elongation	26%
CVN Impact Values	52J @ 0°C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER PKT	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
2.5	2.5	5	159	PH2825
3.2	5.0	3	164	PH2832
4.0	5.0	3	104	PH2840
5.0	5.0	3	53	PH2850

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