

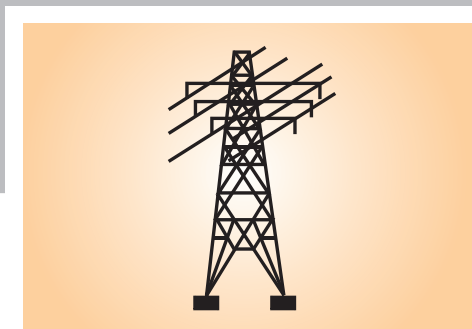
ESSEN[®] HM 28 S

AC/ DC +

Mild Steel electrodes For effective surface treatment

IS: 814:1991, AWS : SFA5.1 E6013

A Rutile Heavy Coated All Position Contact Type General Purpose Welding Electrode for Mild Steel Sheet & Other Fabrications.



PROPERTIES

An all position electrode for high recovery and contact type of welding & for low penetration. Easy to weld at low amperages and at low open circuit voltages. Easy to remove slag.

MECHANICAL PROPERTIES

Tensile strength : 49 Kg / mm² (~ 70,000 psi) Elongation : 21%

APPLICATIONS

For sheet metal fabrication of mild steel strusses, structures, tanks, pipelines, mild steel bases for pumps & motors, frames, fabrication of different sections like T,I,H, beams, also for built up or overlaying on worn out parts of m.s. and also joining dissimilar thickness.

WELDING PROCEDURE.

Clean weld area. Use AC / DC reverse polarity. Maintain a short arc. Thin gauges can be contact welded

| RECOMMENDED AMPERAGE | |
|----------------------|----------------|
| Size | Current |
| 2.50mm x 350mm | 065 - 090 Amps |
| 3.15mm x 350mm | 060 - 125 Amps |
| 4.00 mm x 450 mm | 095 - 160 Amps |
| 5.00 mm x 450 mm | 120 - 200 Amps |

| PACKING | |
|------------------------|---------------------|
| 2.50 mm x 350mm 20 Kg | 42 pcs/kg (Approx) |
| 3.15 mm x 350 mm 30 kg | 33 pcs/kg (Approx.) |
| 4.00 mm x 450 mm 42 kg | 22 pcs/kg (Approx.) |
| 5.00 mm x 450 mm 42 kg | 20 pcs/kg (Approx.) |



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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