

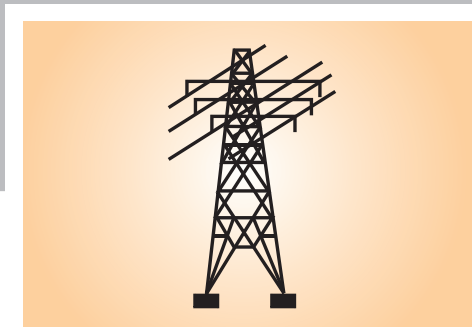
# ESSEN<sup>®</sup> HM 28

AC/ DC +

Mild Steel electrodes For effective surface treatment

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

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



### PROPERTIES

An all position electrode for 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 / mm<sup>2</sup> (~ 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	54 pcs/kg (Approx)
3.15 mm x 350 mm 30 kg	36 pcs/kg (Approx.)
4.00 mm x 450 mm 42 kg	17 pcs/kg (Approx.)
5.00 mm x 450 mm 42 kg	11 pcs/kg (Approx.)



**ESSEN**  
WELDING ALLOYS PVT. LTD.



**ESSEN & AZUCAR**  
PREMIUM WELDING ALLOYS

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