

DESCRIPTION:

The WELDWELL PH28 electrode has a medium-heavy rutile coating and yields a fairly rapidly solidifying slag. This electrode is the answer where a universal rod is desired for welding in all positions.

With this electrode even not so experienced welders will obtain good results since it is **very easy to use**.

The PH28 is extremely suitable for making fillet welds. Welding is then done with a short arc. The weld surface is very smooth and the beads are almost flat. The same applies for unprepared butt welds and for outside corner welds.

The uniform fine-droplet metal transfer and the possibility of using a shorter arc length without risk of short-circuiting and freezing are very helpful in both vertical and overhead welding.

The PH28 may be employed on either AC or DC. When it is used with DC the electrode is normally connected to the negative pole (straight polarity).

For this electrode, use can be made of transformers with a relatively low no-load voltage.

Applications:

Pipe welding on site. Pressure vessels, general construction, hydro installations, ship building. storage tanks.

Welding Positions:

F, H, V, OH

Recommended Amperages

Dia. mm	Length mm	Amperes	Deposition Rate kg/hr*
2.5	305	70-100	
3.2	380	85-135	1.00
4.0	380	130-170	1.45
5.0	380	190-230	2.15
6.0	Available on Special Order only		

* Deposition rate at maximum amps.

AC 50V DC -

Typical Mechanical Properties of Weld Metal

Tensile Strength	500 MPa
Yield Value	448 MPa
Elongation(1 = 5d)	26%
Impact Value Charpy V Notch at 0°C	52 J

AWS A5.1.2004 : E6013
AS/NZS 4855B:2007 : E4313A

WELDWELL

28

**ELECTRODES
FOR WELDING
MILD STEEL**

TIP COLOUR Blue
FLUX MARKING PH28 6013 4313A

Approvals:

American Bureau of Shipping
Lloyds Register of Shipping
Bureau Veritas

Characteristics

Excellent X-ray properties.
Quality for wide range of work.
High efficiency for vertical and overhead.
Smooth arc with very little spatter.
Easy to control and for slag removal.
Fine for fillet welds.
Welding can be done using either AC or DC-

Typical Chemical Analysis

C	0.04%
Mn	0.47%
Si	0.40%

Storage

Store electrodes in a dry place. To recondition moist electrodes bake for half an hour at 120°C in a vented oven.