



## SELECTARC B7028

High Efficiency  
Basic Electrode

### Classification

AWS A5.1 : E7028 EN 499 : E 42 2 B 83  
ISO 2560-A : E 42 2 B 83

### Characteristics

Basic Coated electrode with high recovery (180%) and low hydrogen content to weld heavy section construction steels. Easy to apply, high efficiency in flat position (downhand welding). The deposition rate is nearly as high as semi-automatic processes. Despite its high recovery this electrode guarantees good impact values down to -20°C

### Applications

Heavy supports, Ship buliding, Pressure vessels, Steel works, Agricultural equipment Construction steels for General use , Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

#### Base materials

EN - Designation	Ship Steels	ASTM
S185 - S355	Quality A ,B, C and D	A 285 Gr. C
P235 - P355		A442 Gr. 55,60
GP240R		A414 Gr. C, D, E, F
P235GH - P265GH		A515 Gr. 55,60,65,70
L210 - L360		A516 Gr. 55,60,65,70

### Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
0.075	0.40	1.20	0.017	0.021	base

### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg A <sub>5</sub>	Impact (KV)	
	R <sub>m</sub> (MPa)	R <sub>e</sub> (MPa)		Temp. °C	J
AW	580	450	24	+ 20	160
				- 20	80

### Welding Current & Instructions

Electrode	ØxL (mm)	3.2 x 450	4.0 x 450	5.0 x 450
Current	(A)	130 - 150	160 - 200	200 - 240

Redrying electrode before use 2hr at 300°C, if necessary. Maintain Interpass temperature : < 250°C



1G/PA



2F/PB

AC/+ ~ 70V

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.