

# HYROD 7028

## TOP FEATURES

- Self releasing slag
- Suitable for welding primer painted components
- ~165% recovery
- Excellent weldability on AC and DC
- Free of cracks and good X-ray quality
- ISO-V toughness down to -40°C

## TYPICAL APPLICATIONS

- Shipyard

## CLASSIFICATION

AWS E 7028 H4  
EN ISO 2560-A E 42 4 B 53 H5

## WELDING POSITIONS

Flat/Horizontal

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.1	1.1	0.6	≤0.025	≤0.015

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-18°C/-20°C	-40°C
Required: AWS A5.1		min. 400	min. 490	min. 22	min. 27	
EN ISO		min. 420	500-610	min. 20	min. 47	
Typical values	AW	≥420	510-610	≥26		≥80
	600°C x 2h	≥420	500-600	≥26		≥80

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3,2x350	140-160
4,0x450	175-220

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
3.2x350	SRP	30	1.5	597066-1
4.0x450	SRP	23	2.3	597073-1

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.

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