# ETC PH28

## TOP FEATURES

- Rutile coated MMA electrode for welding mild steel on general construction applications
- Good slag detachability and excellent bead appearance
- Efficiency about 100%
- Operates on low open circuit voltage

## CLASSIFICATION

| | |
|---|---|
| AWS A5.1 | E6013 |
| EN ISO 2560-A | E 42 0 R 1 2 |

## CURRENT TYPE

AC; DC-

## WELDING POSITIONS

All positions, except vertical down

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

| C | Mn | Si | P | S |
|---|---|---|---|---|
| 0.08 | 0.6 | 0.40 | 0.025 | 0.010 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| Required | Condition | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) 4d | Elongation (%) 5d | Impact ISO-V (J) 0°C |
|---|---|---|---|---|---|---|
| AWS A5.1 | AW | ≥330 | ≥430 | ≥22 | - | - |
| EN ISO 2560-A | AW | ≥420 | 500-640 | - | ≥20 | ≥47 |
| Typical values | AW | 430 | 530 | 26 | 24 | 70 |

AW: As-welded

- = not specified

## OPERATING CURRENT RANGE

| Diameter x Length (mm) | Current range (A) |
|---|---|
| 2.5 x 350 | 60-100 |
| 3.2 x 350 | 85-140 |
| 4.0 x 350 | 120-190 |

## AVAILABLE SIZES AND PACKAGING INFORMATION

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|---|---|---|---|---|
| 2.5 x 350 | CBOX | 220 | 4.4 | W000374041 |
| 3.2 x 350 | CBOX | 140 | 4.6 | W000374042 |
| 4.0 x 350 | CBOX | 95 | 4.6 | W000374043 |