

# K-7028LF

**AWS E7028**  
**JIS D5026**  
**KS D5026**

FOR HIGH TENSILE  
 STRENGTH STEEL

## Typical applications

Flat and horizontal fillet welding of 490N/mm<sup>2</sup> class high tensile strength steel structures, large size steel castings and strength members of ship hulls.

## Coating

Low hydrogen, iron powder type.

## Characteristics on Usage

- ① Extremely high deposition rate and good slag removal.
- ② For application of gravity welding and auto-contact welding.
- ③ Redry the electrode at 250~300°C for 60 minutes prior to use.

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.07	0.52	0.98	0.012	0.010

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	Charpy V-notch J {kgf · m} (-18°C)
470 {48}	550 {56}	31	130 {13}

## Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	5.0	5.5	6.0	6.4
Length (mm)	550,700	550,700,900	550,700,900	550,700,900
Amp.	F H-Fil 200~250	220~280	270~320	290~340

## Welding positions



## Approved by

ABS, BV, DNV, GL, KR, LR, NK, JIS