

ETC PH28 SUPERCORD



MMA Electrodes C-Mn and low-alloy steels

SUPERCORD is a medium-coated rutile MMA electrode with a fast freezing slag. Universal all-positional electrode which is very easy to weld, for all light constructional work, including pipework. Suitable for vertical down welding of thin plates. Operates on low open circuit voltage, recommended for tack welding. Good slag detachability and excellent bead appearance. Efficiency 100%.

Classification		Approvals	Grade
EN ISO	2560-A: E 38 0 R 12	ABS	2
AWS	A5.1: E 6013	CE	
GOST	9467-75: ?50-E51 1		

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05-0.11	0.4-0.7	0.2-0.4	≤ 0.03	≤ 0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 430	510-640	≥ 24	≥ 47

Materials

S(P)235 to S(P)355; GP240; GP280

Storage	Current condition and welding position
Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.	AC; DC-

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	BOX	
				PC	Code
2.0	300	40-60	10.5	360	-
2.5	350	65-90	20.1	220	ETC PH2825
3.2	350	100-140	32.4	140	ETC PH2832
3.2	450	100-140	42.0	140	-
4.0	350	140-180	47.4	95	ETC PH2840
4.0	450	140-180	62.1	95	-
5.0	350	170-230	71.4	70	ETC PH2850
5.0	450	170-230	92.9	70	-

