



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

7028 Carbon Steel Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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ALLOY DESCRIPTION AND APPLICATION;

E7028 is an iron powder, low hydrogen electrode developed for high deposition efficiency welding of flat and horizontal fillets, as well as deep groove joints in 71,000 psi, high tensile strength steel. This electrode produces X-ray quality weld deposits which exhibit high cracking resistance and excellent mechanical properties. In addition to its high deposition rate, E7028 provides easy slag removability and a nice bead appearance, free from undercuts. Welding efficiency can be further improved by using a gravity welder. This electrode can be used with AC or DC (reverse polarity). E7028 is used for welding strength members of ship hulls, bridges, heavy machinery parts and fired or unfired pressure vessels.

TYPICAL WELDING PROCEDURES; AC or DCEP

Diameter	Amps (Flat)	Volts
1/8"	90-160	23-27
5/32"	130-200	25-31
3/16"	170-270	25-33
1/4"	250-330	23-33

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES (AWS values are maximum)

	AWS Spec.	Weld Metal		AWS Spec.	Weld Metal
Carbon	0.15 max	0.07	Chromium	0.20 max	0.03
Manganese	1.60 max	0.98	Molybdenum	0.30 max	0.02
Silicon	0.90 max	0.52	Vanadium	0.08 max	0.01
Phosphorus	0.035 max	0.012	Elongation in 2" (%)	22% min	31
Sulphur	0.035 max	0.010	Yield Strength (ksi)	58 min	69
Nickel	0.30 max	0.03	Tensile Strength (ksi)	70 min	81
Mn + Ni + Cr + Mo + V	1.75 max	Charpy V-notch 0°F		20 ft·lbs min	94

AVAILABLE SIZES: TE 7028 = 3/32", 1/8", 5/32"

**SPECIFICATIONS; ANSI/AWS A5.1 E7028
ASME SFA 5.1 E7028**



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