



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

7048 Carbon Steel Coated Electrode

U.S. ALLOY CO.
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ALLOY DESCRIPTION AND APPLICATION;

7048 is an iron-powder-potassium low hydrogen flux coated electrode developed to provide exceptional welding properties for vertical down welding application. 7048 electrodes are designed to weld mild, low carbon, low alloy, and free-machining steels. 7048 has a very good deposition rate, providing a stable arc with extremely low spatter loss with good penetration. 7048 is known for x-ray quality weld deposits with smooth, uniform bead appearance and ease of slag removal. 7048 is designed to operate on AC or DC reverse polarity (DCEP) welding current. 7048 is extensively used for fabrication and repair of fired and non-fired pressure vessels using ASTM A-516 or A-537 plate, process piping using ASTM A-33 or A-523 pipe, shop and field welding or bridges using ASTM A-709 plate, shipbuilding using ASTM A-131 plate, structural steels, cast steels, and cold rolled steels used in heavy machinery fabrication. 7048 is used anywhere welds are deemed critical and subject to x-ray inspection.

TYPICAL WELDING PROCEDURES; AC or DCEP

Diameter	Amps (Flat)	Volts
3/32"	70-170	21-26
1/8"	90-160	23-27
5/32"	130-210	25-31
3/16"	170-270	23-31

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

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld Metal		AWS Spec.	Weld Metal
Carbon	0.15 max	0.07	Chromium	0.20 max	0.03
Manganese	1.60 max	0.97	Molybdenum	0.30 max	0.02
Silicon	0.90 max	0.57	Vanadium	0.08 max	0.01
Phosphorus	0.035 max	0.011	Elongation in 2" (%)	22% min	31%
Sulphur	0.035 max	0.012	Yield Strength (ksi)	58 min	72
Nickel	0.30 max	0.02	Tensile Strength (ksi)	70 min	88
Mn + Ni + Cr + Mo + V	1.75 max		Charpy V-notch -20°F	20 ft-lbs min	58

AVAILABLE SIZES: TE 7048 = 3/32", 1/8", 5/32" 3/16"

**SPECIFICATIONS; ANSI/AWS A5.1 E7048
ASME SFA 5.1 E7048**



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