



Excalibur® 7028

AWS E7028 H8 • Mild Steel, Low Hydrogen

Typical Applications

- ▶ Structural
- ▶ Heavy fabrication
- ▶ Shipbuilding
- ▶ Storage tanks
- ▶ Bridge fabrication

Conformances

AWS A5.1/A5.1M: 2004	E7028 H8
ASME SFA-A5.1:	E7028 H8
ABS:	E7028, 3Y H10 (Fillet Only)
Lloyd's Register:	3YM H10
DNV Grade:	3 YH10
CWB/CSA W48-06:	E4928 H8

Key Features

- ▶ High deposition rates
- ▶ Premium arc performance
- ▶ High travel speed
- ▶ H8 diffusible hydrogen levels
- ▶ Capable of producing weld deposits with impact toughness exceeding 84 J (60 ft•lbf) at -40°C (-40°F)

Welding Positions

Flat & Horizontal

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	50 lb (22.7 kg) Easy Open Can
5/32 (4.0)	14 (350)	ED032636, ED034312*
3/16 (4.8)	18 (450)	ED032790, ED034313*
7/32 (5.6)	18 (450)	ED032638, ED034314*

*Buy America Product

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) @ -18°C (0°F)
Requirements - AWS E7028 H8	400 (58) min.	490 (70) min.	22 min.	27 (20) min.
Typical Results ⁽³⁾ - As-Welded	450-470 (66-69)	540-560 (77-85)	27-34	84-193 (62-142)

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.1/A5.1M: 2004

	%C	%Mn	%Si	%P	%S	%Ni
Requirements - AWS E7028 H8	0.15 max.	1.60 max.	0.90 max.	0.035 max.	0.035 max.	0.30 max.
Typical Results ⁽³⁾	0.03-0.06	1.17-1.51	0.44-0.77	0.007-0.014	0.004-0.008	0.02-0.04
	%Cr	%Mo	%V	%Mn + Ni + Cr + Mo + V	Diffusible Hydrogen (mL/100g weld metal)	
Requirements - AWS E7028 H8	0.20 max.	0.30 max.	0.08 max.	1.75 max.	8.0 max.	
Typical Results ⁽³⁾	0.02-0.05	0.01-0.03	0.02 max.	1.25-1.62	4-5	

TYPICAL OPERATING PROCEDURES

Polarity ⁽⁴⁾	Current (Amps)		
	5/32 in (4.0 mm)	3/16 in (4.8 mm)	7/32 in (5.6 mm)
AC	130-180	190-250	250-310
DC+	125-175	185-245	220-280

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer on pg. 18. ⁽⁴⁾Preferred polarity is listed first.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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