

7014 PRODUCT DATA SHEET

Classification AWS A5.1 : E 7014 EN 499: E 42 0 RR 33 ISO 2560-A: E 42 0 RR 33

Description and Applications

An iron powder heavy coated rutile type electrode specially designed for fast welding speed. Gives excellent stable arc, least spatters, fine ripples and very easy slag removal. Weld metal is of radiographic quality. Deposition efficiency 115% approx. Suitable for all mild steel structures, pressure vessels, boilers, wagons, tanks, ships etc.

Base materials

Construction steels for general use , Tube steels, Ship steels

EN- Designation:	S185 - S355	L210 - L360
	P235 - P355	
Ship Steel:	Quality A and B	
ASTM:	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.07	0.25	0.65	0.025	0.020

All weld metal Mechanical Properties (Typical)

Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation A ₅ (%)	Charpy Impact ISO-V J +0°C
510-600	≥400	≥24	≥47

Amperes (A)

2.00mm	2.40mm	2.50mm	3.15mm	3.20mm	4.00mm	5.00mm
45-75	70-90	70-90	110-140	110-140	140-180	180-230

Welding Instruction

Keep dry and avoid condensation.

Welding Positions

