

Sureweld 7014

Sureweld 7014 is an iron powder coated electrode permitting the use of higher welding currents while improving the deposition rate. High speeds and high heats can be used without undercut. Slag removal is excellent. Sureweld 7014 is widely used for welding mild steels such as ASTM A-36, A-113, A-283, A-284, A-285, A-306, A-515 and A-516. Typical applications include construction equipment, metal fixtures, automotive parts, barges and farm machinery.

Specifications	
Classifications	ASME SFA 5.1 : E7014 AWS A5.1 : E7014
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Welding Current	DC+-, AC
Alloy Type	Carbon Manganese

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	420 MPa (61 ksi)	490 MPa (71 ksi)	28 %

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.04	0.30	0.14	0.02	0.02

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 356.0 mm (3/32 x 14.0 in.)	70-100 A	60.0 %	0.86 kg/h (1.9 lbs/h)
3.2 x 356.0 mm (1/8 x 14.0 in.)	100-150 A	61.1 %	1.41 kg/h (3.1 lbs/h)
4.0 x 356.0 mm (5/32 x 14.0 in.)	160-200 A	69.5 %	1.52 kg/h (3.4 lbs/h)
4.8 x 350.0 mm (3/16 x 13.8 in.)			0.0 kg/h (0.0 lbs/h)