7014

DESCRIPTION: Weldcote Metals 7014 is an iron powder, rutile type electrode designed to operate at higher speeds with greater deposition efficiency than Weldcote Metals 6012 or 6013 electrodes. This electrode provides a stable arc, flat smooth bead appearance and easy slag removability. 7014 is used for all position, single-pass and multi-layer welding applications. AC or DC (straight or reverse polarity) may be used.

APPLICATIONS: 7014 is an all-purpose electrode used wherever the welding efficiency of 6012 or 6013 is not acceptable. Typical application would include: ship structures, bridges, structural steel for buildings, sheet metal, ornamental iron, auto bodies and fenders, machine parts, storage tanks, etc.

SPECIFICATIONS: ANSI/AWS A5.1 & ASME SFA 5.1 E7014

CHEMICAL COMPOSITION

CARBON	0.12%
SILICON	0.33%
PHOSPHORUS	0.021%
COPPER	0.012%
CHROMIUM	0.041%
VANADIUM	0.023%
MANGANESE	0.68%
IRON	Balance
SULFUR	0.012%
NICKEL	0.053%
MOLYBDENUM	0.002%

MECHANICAL PROPERTIES

Tensile Strength	79,000 PSI
Yield Strength	67,700 PSI
Elongation	29.4

* RECOMMENDED WELDING PARAMETERS:

		3/32 X 12	1/8 X 14	5/32 x 14
AMPS	Flat	**100-110**	**130-140**	**190-200**
	Vertical/overhead	**80-90**	**120-130**	**150-160**

*** All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.