

# S-7014.F

TYPE : Rutile

AWS A5.1 / ASME SFA5.1 E7014  
EN ISO 2560-A - E42 0 R 1 2

SMW

## Applications

This electrode is suitable for all types of carbon steel fabrications, particularly in horizontal fillet welding of sheet metal and ornamental iron work.

## Characteristics on Usage

S-7014.F is an iron powder electrode for high speed all position welding. As the contact welding can be performed with this electrode, manipulation of electrodes is easy in horizontal fillet or in the groove.

## Notes on Usage

- ① Dry the electrodes at 70~100°C(158~212°F) for 30~60 minutes before use.
- ② Pay attention not to exceed the range of proper currents.

## Welding Position



1G (PA)    2F (PB)    3G (PF)    4G (PE)

## Current

AC or DC ±

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.30	0.66	0.022	0.015

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
449 (65,200)	510 (74,100)	30.9	0 (32)	83 (61)

## Approval

KR, ABS, LR, BV, DNV, GL, NK

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	400 (16)	400 (16)	400 (16)	450 (18)
F	95~140	140~200	180~250	240~310