

# Sureweld 7014

Sureweld 7014 is an iron powder coated electrode permitting the use of higher welding currents while improving the deposition rate. The use of an iron powder coating also improves deposition efficiency. 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.

<b>Classifications:</b>	AWS A5.1:E7014
<b>Industry or Segmentation:</b>	Industrial and General Fabrication, Mobile Equipment, Ship/Barge Building

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
As Welded	420 MPa (61 ksi)	490 MPa (71 ksi)	64 %	28 %

## Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.04	0.30	0.14	0.02	0.02

## Deposition Data

Diameter	Amps	Deposition Rate	Efficiency (%)
2.4 mm (3/32 in.)	70-100 A	0.9 kg/h (2 lb/h)	60 %
3.2 mm (1/8 in.)	100-150 A	1.1 kg/h (2.4 lb/h)	63.9 %
3.2 mm (1/8 in.)	100-150 A	1.4 kg/h (3.1 lb/h)	61.1 %
4.0 mm (5/32 in.)	160-200 A	1.4 kg/h (3 lb/h)	71.9 %
4.0 mm (5/32 in.)	160-200 A	1.7 kg/h (3.7 lb/h)	67 %