

# SUREWELD 7014

AWS A5.1: E7014

## FEATURES

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.

## CLASSIFICATIONS AND APPROVALS

- AWS A5.1: E7014
- ASME SFA 5.1

## WELDING PROCESS

- SMAW (Stick)

## INDUSTRIES

- General Fabrication
- Mobile Equipment
- Barges

## TYPICAL MECHANICAL PROPERTIES

As Welded	
Yield Strength	61 ksi, 420 MPa
Tensile Strength	71 ksi, 490 MPa
Reduction in Area	64%
Elongation in 2"	28%

## WELD METAL ANALYSIS

C	0.04%
Mn	0.3%
Si	0.14%
P	0.015%
S	0.019%

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## DEPOSITION TABLE

Diameter in (mm)	Optimal Current Amps	Current Range Amps	Deposition Rate lb/hr (kg/hr)	Efficiency %
3/32 (2.4)	85	70 - 100	2 (0.9)	60
1/8 (3.2)	120	100 - 150	2.4 (1.1)	63.9
	150	100 - 150	3.1 (1.4)	61.1
5/32 (4.0)	160	160 - 200	3 (1.4)	71.9
	200	160 - 200	3.7 (1.7)	67

## PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
812000206	SW 7014 1/8X14X5#VALP	662303202965
812000214	SW 7014 1/8X14X50#CTN	662303202972
812000180	SW 7014 3/32X14X5#VALP	662303202941
812000198	SW 7014 3/32X14X50#CTN	662303202958
812000222	SW 7014 5/32X14X5#VALP	662303202989
812000230	SW 7014 5/32X14X50#CTN	662303202996

