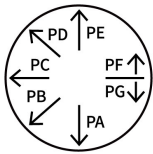


S-7014.F

Classification

AWS A5.1/ASME SFA-5.1 E7014
EN ISO 2560-A E42 0 R 1 2

Welding Positions



Features

- High welding speed
- Easy horizontal fillet and groove welding

Polarity

AC or DC ±

Application Areas

- General fabrication

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

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

C	Si	Mn	P	S
0.08	0.27	0.70	0.020	0.007

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
423(61)	510(74)	31	0(32)	72(53)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
3.2 (1/8)	400(16)	95-140	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.0 (5/32)	400 (16)	140-200	
5.0 (3/16)	400 (16)	180-250	
6.0 (15/64)	450 (18)	240-310	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux