

TECHNICAL

DATA SHEET



**Sureweld 7014 Covered (Stick)
Electrodes (SMAW) Mild Steel Electrodes**

Art. No. 984.812000...

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PRODUCT DESCRIPTION

Sureweld 7014 is an iron powder coated electrode permitting the use of higher welding currents while improving the deposition rate. 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	AWS A5.1 : E7014
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, DC- or AC
Coating Type	Iron powder, titania

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

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Deposition Data

Diameter	Current	Deposition Rate	Deposition Efficiency %
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 %
2.4 mm (3/32 in.)	70-100 A	0.9 kg/h (2 lb/h)	60 %
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 %

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2021

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