

CLASSIFICATION

EN ISO 2560-A : E 42 0 RR 12
AWS A5.1 : E7014

GENERAL DESCRIPTION

L-7014 is a heavily coated rutile electrode. Weld metal has a high resistance to cracking in multipass applications. The slag is easy to remove and it gives high quality, smooth weld beads. It is easy to strike and re-strike and thus an ideal electrode for tacking. It is an easy to use electrode. It has about 100% metal recovery due to high iron powder content in its coating.

APPROVALS

CE, GOST, SEPRO, TSE

ABS	BV	DNV	GL	LRS	TL
2	2	2	2	2m	2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 470 N/mm ²
Tensile Strength	: 550 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 60 J (0°C) 40 J (-20°C)

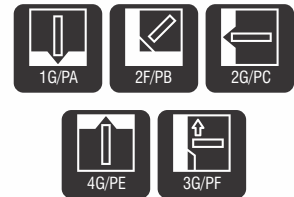
CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.08	0.40	0.60

WELDING PARAMETERS / PACKAGING AND AVAILABLE SIZES / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (-)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.00	300	50 - 70	1130	1.7 / 150	2
2.50	350	60 - 00	2120	2.1 / 100	5
3.25	350	95 - 145	3190	3.2 / 100	5
4.00	350	140 - 190	4830	4.8 / 100	5
5.00	350	180 - 245	7410	4.8 / 65	5



APPLICATIONS AND MATERIALS TO BE WELDED

L-7014 is a general purpose electrode for welding mild steels. Bridging over fairly large gaps that can occur in site welding where preheating is not possible, galvanized plates, rusty or dirty surfaces, ordinary ship's plate of A- and D- quality, automotive bodies and general structural steels are among its application areas.

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 420	S255N - S420N
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM	L210 - L360NB L290MB - L360MB
Boiler and Pressure Vessel Steels	17 Mn 4 H1, H11, H111	P295GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, D	-
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.