

K-7014

AWS E7014

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

All position fillet welding of ship structures, bridges, structural steels for buildings and general structures.

Coating

Iron powder, titania type.

Characteristics on Usage

- ① Designed for high efficiency in single pass and multiple pass welding.
- ② Excellent slag removal and good bead appearance.
- ③ Redry the electrode at 100~130°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.08	0.35	0.60	0.015	0.010

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
470 {48}	550 {56}	30	80 {8}

Sizes available and recommended currents (AC or DC ⊕, ⊖)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
Amp.	F 60~100 V&OH 50~90	90~140 80~130	140~200 110~170	190~240 150~200	250~310 -

Welding positions



Approved by

ABS, CWB, KR, LR, NK