

S-7014.F

Type : High recovery Rutile

Conformances

AWS A5.1/ ASME SFA5.1 E7014
EN ISO 2560-A-E42 0 R 1 2
KR 2, 2Y
ABS 2Y
LR 2, 2Y
BV 2, 2Y
DNV-GL 2, 2Y
NK KMW52

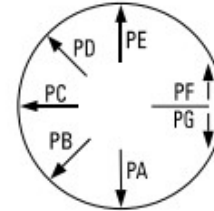
Applications

- General fabrication

Features

- High welding speed
- Easy horizontal fillet and groove welding

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.30	0.66	0.022	0.015

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
449 (65,200)	510 (74,100)	30.9	0 (32)	83 (61)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	400 (16)	400 (16)	400 (16)	450 (18)
F	95~140	140~200	180~250	240~310

Diam.	Pack/Carton	Part No.
3.2mm	5kg/ 20kg	HKS-7014F32

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