

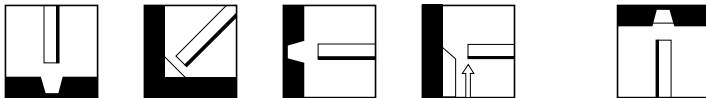
Classifications

EN ISO 2560-A:2006	: E 42 A RR 32	JIS Z 3211	: E4914
EN ISO 2560-B:2006	: E 49 14 A		
AWS A5.1-04	: E7014		

Description

- Covering is iron powder, titania type for fillet welding of ship structure, bridges, structural steels.
- Designed for high efficiency in single pass and multiple pass welding.
- Excellent slag removal and good bead appearance.
- Quiet and stable arc.
- Redry the electrode at 120~150°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.08	0.41	0.73	0.020	0.014	0.02	0.03	0.01	0.01	0.80

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	0°C	
AWS A5.1	min. 400	min. 490	min. 17			
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	470	550	30	65	50	AW

* AW : As-Welded

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. (A)	F V · OH	60~100 50~90	90~140 80~130	140~200 110~170	190~240 150~200	250~310 -

Approvals

ABS	KR	LR	NK
2Y,E7014	2Y	2Ym	KMW52

* Others : JIS, CWB, CE