



Standards: AWS/ASME SFA - 5.1 E 7014

Application / Properties: High metal recovery rutile electrode, due to iron power. Suitable for welding AC and DC. Easy removal & smooth bead appearance.

Weld metal analysis in % (typical values):

C	Mn	Si	S	P
0.09	0.45	0.35	0.02	0.02

Mechanical Properties of all-weld metal:

(Single values are typical values)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation A5 (%)	Impact energy (J) ISO - V + 20 °C
>490	>400	>20	>70



Welding Parameters		
Diameter (mm)	4	5
Length (mm)	350	450
Amperage(A)	150-190	180- 280



Materials:

DIN Standard	St 37-2 to St 52-2; St 37.0 to St 52.0; St 37.4 to St 52.4; StE 210.7 to StE 360.7; StE 210.7 TM to StE 360.7 TM; St 35.8 to St 45.8; HI; HII; 17mn4; GS-38 ; GS-52.
EN Standard	S235JR to E295; P235T1 to P355T1; P235T2; P355T2; L210 to L360NB; L290MB to L360MB; P235G1TH; P255G1TH; P235GH; P265GH; P295GH.
ASTM Standard	ASTM A36 a. A53 Gr. all; A106 Gr. A, B, C, A 135 Gr. A, B; A283 Gr. A, B, C, D; A366; A285 Gr. A, B, C; A500 Gr. A, B, C; A570 Gr. 30, 33, 36, 40, 45, 50, 55; A607 Gr. 45, 50; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A935 Gr.45; A936 Gr. 50.

Redrying: If necessary 1 h at 100-120C