T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

ISO 9001
Cert. No. 31598

E7014 COVERED ELECTRODE

NOMINAL COMPOSITION:

Carbon	.15%	Chromium	.20%
Manganese	1.25%	Copper	.012%
Sulfur	0.035%	Silicon	.90%
Nickel	0.30%	Phosphorus	.035
Vanadium	.08%	Molybdenum	.30
Iron	Balance	Combined Limit	1.5 (Mn,Ni,Cr,Mo,V)

PHYSICAL PROPERTIES:

Density lbs/cu in .283

TYPICAL MECHANICAL PROPERTIES AS WELDED

Tensile Strength (psi)	up to 79,900 psi
Yeild Strength (psi	67,700
Elongation in 2”	29.4

WELDING PROPERTIES:

E7014 is an all position steel electrode with Rutile-iron powder which yields a high deposition rate with smooth beads and fine ripples. E7014 can be used when poor fit ups exists and where higher deposition and speed of travel is needed. This electrode is recommended for areas such as machine bases, frames, heavy sheet metal, shelving, general maintenance and fabrication which operates with AC, DCEN or DCEP. Also has self-lifting easy removing slag.

Vertical up / Overhead: Use slight whipping or weaving

Vertical down: Use higher amperage and faster travel speed staying ahead of the puddle

* RECOMMENDED WELDING PARAMETERS:

AMPS	3/32x12	1/8x14	5/32x14
Flat	100-110	130-140	190-200
Vertcal/overhead	80-90	120-130	150-160

*** All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

*Additional information available at our web site: **www.harrisproductsgroup.com***

03/08 MK

SPECIFICATION COMPLIANCE: ANSI/AWS A5.1 &ASME SFA 5.1 E7014

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes,* published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

Additional information available at our web site: ***www.harrisproductsgroup.com***
03/08 MK