



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# 7014 Carbon Steel Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



## ALLOY DESCRIPTION AND APPLICATION;

**E7014 is an iron powder, rutile type electrode designed to operate at higher speeds with greater deposition efficiency than E6012 or E6013 electrodes. This electrode provides a stable arc, flat smooth bead appearance and easy slag removable. E7014 is used for all position, single-pass and multi-layer welding applications. AC or DC (straight or reverse polarity) may be used. 7014 is an all-purpose electrode used wherever the welding efficiency of E6012 or E6013 is not acceptable. Typical application would include: ship structures, bridges, structural steel for buildings, sheet metal, ornamental iron, auto bodies and fenders, machine parts, storage tanks, etc.**

## TYPICAL WELDING PROCEDURES; AC, DCEP, DCEN

Diameter	Amps (Flat)	Volts
3/32"	70-170	21-26
1/8"	90-160	23-27
5/32"	130-210	25-31

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld metal		AWS Spec.	Weld metal
Carbon	0.15 max	0.70	Chromium	0.20 max	0.040
Manganese	1.25 max	0.45	Molybdenum	0.30 max	0.003
Silicon	0.90 max	0.32	Vanadium	0.08 max	0.001
Phosphorus	0.035 max	0.14	Elongation in 2" (%)	17% min	30%
Sulphur	0.035 max	0.008	Yield Strength (ksi)	58 min	69
Nickel	0.30 max	0.051	Tensile Strength (ksi)	70 min	79
Mn + Ni + Cr + Mo + V	1.50 max		Charpy V-notch	N/S	58

**AVAILABLE SIZES: TE 7014 = 3/32" , 1/8" , 5/32"**

**SPECIFICATIONS; ANSI/AWS A5.1 E7014  
ASME SFA 5.1 E7014**

**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4755 Alpine Drive #100A  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586



Warehouse Distribution Center – Portland, Oregon

Head Office – Puyallup, Washington

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