DURAMAX®
Inspiring the future generations of welders

Product
Data Sheet

DM7014 Premium Electrode

Classification: **E7014**
AWS A 5.1 / ASME SFA 5.1

DuraMax DM7014 is a MEDIUM HEAVY COATED, IRON POWDER & RUTILE TYPE WELDING ELECTRODE FOR HIGH DEPOSITION EFFICIENCY 115% MIN

Characteristics

Medium heavy coated, iron powder, rutile type electrodes designed for high efficiency welding jobs. Deposition efficiency exceeds 115% and weld are of radiographic quality.

Typical Applications on Usage

1) Suitable for thicker sections machinery components.
2) Heavy mild steel structurals
3) Boilers and pressure vessels.
4) Bridges, wagons, tanks and vessels.
5) Ships, girders, barges etc.

RE-DRY CONDITIONS: Re-Dry the electrode at 120°C for one hour, for best results.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.15 max	1.25 max	0.90 max	0.035 max	0.035 max	0.30 max	0.20 max	0.30 max	0.08 max

Typical Mechanical Properties as Welded

Tensile Strength (n/mm^2)	Yield Strength (n/mm2)	Elongation (%) (1=4d)	Hardness	Ferrite WRC (FN)	CVN Impacts (J) @ 0 °C
490 min	400 min	17 min	-------	-------	80-100 J

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	70 ~ 110	100 ~ 150	160 ~ 200

POLARITY: DCEN or AC
DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL ; MORE AMPS ON THICK METALS

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