WELDWIRE COMPANY, INC. **Technical Information**

Mild Steel Electrodes

Alloy: WW7014 Certification: AWS A5.1
Class: E7014 ASME SFA A5.1

Alloy: E7014

Weld Process: Shielded Manual Metal Arc Electrodes

AWS Chemical Composition Requirements

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

Note: Combined elements of Mn + Ni + Cr + Mo + V the limits shall not exceed a combined total of 1.50.

Deposited Chemical Composition % (Typical)

C = 0.08 Mn = 0.50 Si = 0.40

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength (PSI)	65,200
Tensile Strength (PSI)	79,500
Elongation in 2” (%)	25

Deposited Charpy-V-Notch Impact Properties %
(Typical) As-Welded

44 ft. lbs. (tested at +30°F)

Recommended Welding Parameters

Diameter	Amperage
3/32”	60 - 100
1/8”	80 – 150
5/32”	100-200

Current (AC or DC, either polarity)

Application

Recommended for simple and multipass welding of structural steels and galvanized steels. Excellent weldability in all positions.

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266