

Inweld 7014 High Speed – Iron Powder

Alloy E7014
AWS A5.1 E7014



AC/DC + (reverse polarity)

Description and Applications:

- *Easy to use, high speed electrode for welding carbon and low alloy steels.
- *Designed to run at higher amperage settings yielding greater deposition efficiency than 6012 or 6013 electrodes. Can be used on small AC as well as large DC machines.
- *Excellent re-strike capability, stable arc, low spatter, easy slag removal and a smooth weld bead with fine ripples are all characteristics of this electrode.
- *For single or multiple-pass applications and in all positions including vertical down and overhead.
- *Great for bridging over wide root openings created by poor joint fit-ups.
- *Commonly used for tack welding sheet metal or galvanized, rusty or dirty plate steels. Other uses include ornamental iron, mobile home frames, automobiles and railcars, storage tanks, machine parts, structural steel for buildings.

Procedure:

A clean weld area will always yield the best results. You can use a small AC machine or a DC machine (electrode + reverse polarity). Set your amperage to the proper range for the size electrode and the welding position you are using. Welding with excessive current not only lowers weld quality, but also causes an increase in spatter and undercuts, so be conscientious of the proper setting. A medium arc length of approximately 1/8" maintained ahead of the weld puddle will yield good wetting action and allow unwanted gases to escape. Flat and horizontal welding: hold the electrode at an angle 10-15 off 90 and use a slight bank and forth whipping motion. Overhead welding: use a slight circular motion. Vertical-down welding: use stringer beads or a slight weaving technique keeping the weld puddle in place by pointing the electrode up into the puddle. Be sure to choose an amperage in the upper end of the recommended range. Vertical-up welding: should be done using the shelf or step method, adding layer on top of layer. Do not use the whipping motion. Use an amperage setting in the lower end of the recommended range. Allow the part to air cool and remove slag with a chipping hammer and brush to a nice finish.

Recommended Parameters	Diameter	Recommended Amperage	
		(F)	(V & O)
	1/16" (1.6mm)	20-40	20-40
	5/64" (2.0mm)	25-60	25-60
	3/32" (2.4mm)	50-100	40-90
	1/8" (3.2mm)	90-140	60-90
Tensile Strength up to 79,000 psi	5/32" (4.0mm)	150-210	110-160
	3/16" (4.8mm)	200-240	120-160

Warning

- This product, when used for welding or cutting, produces fumes or gases which may contain chemicals known to the state of California to cause birth defects (or other reproductive harm), and in some cases cancer. (California Health & Safety Code 25249.5 et seq.)
- Read American National Standards Z49.1, "Safety in Welding Cutting and Allied Processes," from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.

Fumes and Gases can be hazardous to you health.

- Before use, read and understand the materials Material Safety Data Sheet (MSDS), the manufacturer's instructions and your employers safety practices.
- If MSDS is not enclosed, obtain one from your employer.
- Keep your head out of the fumes. See section 5 of the MSDS for specific fume concentration limits.
- Use enough ventilation exhaust at the arc or both to keep fumes and gases from your breathing zone and general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding. Electric Shock can kill.
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- ARC Rays can injure eyes and burn skin.
- Wear welding helmet with correct filter.
- Wear correct eye, ear and body protection.
- Welding can cause fire or explosion" Do not weld near flammable material.
- Watch for fire, keep extinguisher nearby.

