

# **ESR 14**



General purpose rutile electrode with high deposition rate – AWS/ASME SFA – 5.1 E7014

## **Key Benefits**

- Preferably used in mild steel fabrication, sheet metal and ornamental iron works on poor fitup joints. Due to its iron powder addition in covering, particularly suited for the welding of horizontal fillets grooves with higher speed.
- Suitable for all position welding except verticaldown. High current carrying capacity, low spatter.
   Quite, stable arc characteristics with fine and fast droplet metal transfer.
- Very easy arc striking and re-striking. Very smooth welds blending into base metal without undercuts.
   Slag is completely self-releasing. Possible to use equally well both with AC and DC.

#### **Welding Positions**



### **Typical applications**

 Used in mild steel fabrication, sheet metal and ornamental iron works on poor fitup joints. Due to its iron powder addition in covering, particularly suited for the welding of horizontal fillets

#### Typical Analysis in %

Requirements – AWS E7014 Typical Wire Composition	<b>%C</b> 0.06	<b>%Mn</b> 0.55	<b>%Si</b> 0.40	%S	%Р
Requirements - AWS E7014 Typical Wire Composition	%Cr	%Ni	%Mo	%Cu	%V

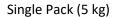
#### **Mechanical Properties**

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Ferrite Number (FN)
Requirements – AWS E7014	500 MPa	560 MPa	28	0°C → 50J
As welded				

# **Ordering Information**

Product Number	Product/AWS	Dimension	Single Pack Weight	Box Weight
	Specification	mm/inches	kg/lb	kg/lb
1114010M15	ESR 14 (E7014)	2.50 x 350 mm (3/32" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1114016M15	ESR 14 (E7014)	3.25 x 350 mm (1/8" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1114020M15	ESR 14 (E7014)	4.00 x 350 mm (5/32" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1114032M15	ESR 14 (E7014)	5.00 x 350 mm (3/16" x 14")	6.5 kg (14.0 lb)	19.5 kg (41.8 lb)







Box (15 kg)