

# RATNA 7014

**Medium heavy coated, Iron powder & rutile type welding Electrode for high deposition efficiency 115% Min.**

**CLASSIFICATION** : AWS/SFA-5.1: E 7014,  
IS-814: ERR 5222 X J ,

**APPROVAL** :

**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.

**APPLICATION** :

- 1) suitable for thicker sections machinery components.
- 2) Heavy mild steel Structural's.
- 3) Boilers and pressure vessels..
- 4) Bridges, wagons, tanks and vessels.
- 5) Ships, girders, barges etc.

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

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.15 max.	1.25 Max.	0.90 Max	0.035 Max	0.035 Max

## ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
400 Min.	490 Min.	17 Min.	0°C : 80-100 J

## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC-/AC)	No. of Pcs./pkt.	No. of Pcs./Case
2.50x350	3/32x14"	70-110	170	680
3.15/3.20 X 450	1/ 8"X18"	100-150	155	620
4.00 X 450	5/ 32"X18"	160-200	80	320
5.00 X 450	3/ 16"X18"	200-250	62	248

Customer packing on request.