

CR-14

For highly efficient welding of steel sheets.

AWS A5.1 E7014
KS D 7004 E4313

Applications

Welding of ships, railway vehicles, cars and general structures.

Characteristics

CR-14 is an iron powder electrode for high speed all position welding. As the contact welding can be performed with this electrode, manipulation of electrodes is easy in horizontal fillet in the groove. Slag removal and bead appearance are good.

Notes on usage

- (1) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lowers X-ray soundness, but also causes increase of spatter, undercut and insufficient slag covering.
- (2) Dry the electrodes at 70~100°C for 30~60 minutes before use. Excessive moisture absorption lowers usability and may result in some porosities.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.58	0.27	0.014	0.011

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	IV J (kgf-m)
			0°C
470(48)	560(57)	29	150(15)

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.6	3.2	4.0	5.0	5.0	6.0	
	L (mm)	350	350	400	400,450	450	450
Amp.	F	60-100	90-130	130-190	200-240	230-270	250-300
	V&OH	50-80	70-130	100-170	160-210	-	-

• Tip Color : Gray