

JACKSUN ULTRA-14

RUTILE TYPE ELECTRODES DESIGNED FOR HIGH
EFFICIENCY WELDING JOBS

BASIC ALLOY: FE, MN, SI
AWS/SFA-5.1: E7014
EN ISO 2560-A E 42 0 R 14

KEY FEATURES:

Medium heavy coated, iron powder, rutile type electrodes designed for high efficiency welding jobs. Deposition efficiency exceeds 115% and weld are of radiographic quality.

APPLICATIONS

- Suitable for thicker sections machinery components.
- Heavy mild steel Structure's.
- Boilers and pressure vessels.
- Bridges, wagons, tanks and vessels.
- Ships, girders, barges etc

RE-DRY CONDITION:

- Re-Dry the electrode at 120°C for one hour, for best results.

CHEMICAL COMPOSITION:

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

MECHANICAL PROPERTIES:

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
400 Min.	490	17min	0C : 80-100 J

WELDING POSITION

1G/1F



2G/2F



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC-/AC) Amps	Kg/pkt.	Kg/Case
2.50/ 2.40	3/ 32"	70-110	5	20
3.15/ 3.20	1/ 8"	100-150	5	20
4.00	5/ 32"	160-200	5	20
5.00	3/ 16"	200-250	5	20