

Standards

AWS A5.35: UWE7014-1A

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Ni
0.05	0.30	0.50	0.30

Mechanical Properties (Typical)

Conditions	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
			ISO-V(J) -20°C	(ISO-V) (Joule) (0°C)	
Level1	min. 350	min. 490	-	min. 50	min. 8
Wet	484	539	44	53	11

Typical Base Material Grades

- Mild Steels, Carbon Steels

Features and Applications

- Designed for general underwater wet welding applications up to 20m water depth.
- Simple to use in all positions in fresh and salt water.
- Provides high quality welding seam in accordance with International Standards in underwater welding applications.
- Modified rutile flux coating offering a continuous weld shape beads.
- Waterproof coating prevent the solubility of the hydrogen from the water to weld metal and provides diver's safety.
- Good root and sidewall penetration and overhead fusion properties.
- Easy to strike and re-strike.
- Best at filling large gaps and weld metal deposition rate. Easy slag removal.

Welding Positions

Current Type

D.C. (-) or D.C. (+)

Operating Data

Product Code	Diameter x Length (mm)	Welding Current (A)	Weight g / 100 pcs
3030100099	∅ 3,2 x 350	140-180	3350
3030100100	∅ 4,0 x 350	160-210	5000