

OVERCORD is a medium thick rutile-cellulosic coated MMA electrode for structural steelwork, workshop and maintenance applications, welding can be carried out with the same current setting in all positions.

Suitable for trade, use in structural engineering, vehicle and shipbuilding. Can be used on primer painted and slightly rusted parts, as there is a high tolerance to impurities. The strong and stable arc makes OVERCORD suitable for welding galvanised steel components.

Excellent all positional operating characteristics, especially vertically-down and the arc characteristics ensures reliable penetration. Welding in the vertical-down position produces flat, slightly concave weld beads. Good gap bridging and easy striking and restriking. Used on mains transformers. If a softer arc is required OVERCORD Z is recommended.

Classification

EN ISO	2560-A: E 38 0 RC 11
AWS	A5.1: E 6013

Approvals

Approvals	Grade
ABS	1
BV	1
DB	●
DNV	1

Approvals

Approvals	Grade
GL	1
LRS	1m
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.08	0.5	0.3

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	0 °C
As Welded	≥ 380	470-600	≥ 22	≥ 60	≥ 47

Materials

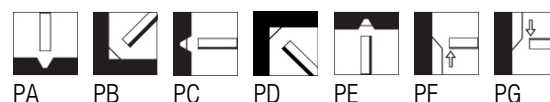
S(P)235 - S(P)355; GP240; GP280

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary 100°-110°C for 1 hour, max. 3 times.

Current condition and welding position

AC; DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
2.0	250	50-60	7.8	205	W000287109		
2.5	350	60-85	16.36			275	W000287110
3.2	350	90-130	28.13			160	W000287111
4.0	350	140-180	42.86			105	W000287112