OVERCORD

MMA Electrodes
C-Mn and low-alloy steels

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. Excellent all positional operating characteristics, especially vertically-down and the arc characteristic 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 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. Used on mains transformers. If a softer arc is required OVERCORD Z is recommended.

Classification	
EN ISO	2560-A: E 38 0 RC 11
EN	499: E 38 0 RC 11
AWS	A5.1: E 6013

Approvals	Grade
ABS	1 (P)
BV	1
DB	●
DNV	1
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.

Current condition and welding position

AC; DC-

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
2.0	250	50-60	7.8	205	●		
2.5	350	60-85	16.2			275	●
3.2	350	90-130	28.0			160	●
3.2	450	120-140	41.8			139	●
4.0	350	140-180	43.0			105	●
4.0	450	170-190	64.5			90	●
5.0	350	180-240	67.5			70	●