

MMA Electrodes C-Mn and low-alloy steels

Rutile coated electrode, used for the welding of large structures and process pipe work in the shipbuilding and construction industries where precise fit-ups are difficult to achieve. OVERCORD S is a high quality electrode designed to give high impact toughness properties at -20 °C. The electrode formulation promotes a forceful arc to ensure sound fusion and is tolerant to variations in welding current, which are important considerations when welding under site conditions.

Classification	
AWS	A5.1: E6013
EN	499: E 38 2 R 12
EN ISO	2560-A: E 38 2 R 12

Approvals	Grades
ABS	
BV	
DNV	
LRS	
MOD	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	0.50	0.20	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 380	470-600	≥ 22	≥ 47	-

Materials

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

Storage and redrying

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

Current condition and welding position

DC+; DC-; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	60-80	9,1	5,5
3,2	350	110-135	21,3	12,8
4,0	450	160-180	47,5	28,5
5,0	450	180-210	70,4	42,2