

OVERCORD R10

MMA Electrodes C-Mn and low-alloy steels

Rutile electrode for welding in all positions. Used for a wide variety of applications.. Efficiency 100%.

Classification

AWS	A5.1: E6013
EN	499: E 38 0 RC 11
EN ISO	2560-A: E 38 0 RC 11

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.10	0.50	0.40	≤ 0.030	≤ 0.030	-	-	-	-	-	-	-

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	480-550	≥ 24	≥ 28	-

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-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	350	50-60	13,0	6,6
2,5	350	60-90	18,4	10,8
3,2	350	100-140	27,6	17,5
3,2	450	100-140	36,6	27,4
4,0	350	150-190	48,8	27,7
4,0	450	150-190	56,8	37,0
5,0	450	190-240	89,3	56,7