

OVERCOD E is a rutile medium coated electrode, especially developed for welding mild steel for light metallic constructions and thin sheet.

Suitable for trade, use in structural engineering, shipbuilding, vehicle and agricultural machines, made of steel with max. 0,25%C, for service temperature up to 0C.

Excelent striking and restraking characteristics. Electrodes welds with a stabile arc and very spattering loss. The slag is self-releasing. Very good weldability on AC and DC- current.

### Classification

EN ISO	2560-A: E 42 0 R 12
AWS	A5.1: E 6013

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.08	0.5	0.4	≤0.03	≤0.02

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 430	490-550	≥ 24	≥ 47

### Materials

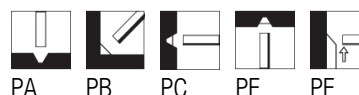
S(P)235 to S(P)355; GP240; GP280

### 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
1.6	250	35-50	5.9	250	W000380863		
2.0	300	50-70	11.8	161	W000380865		
2.5	300	60-90	16.03			237	W000380867
2.5	350	60-90	19.57			230	W000287158
3.2	350	110-135	31.91			141	W000287159
3.2	450	110-135	41.73			139	W000287160
4.0	350	160-180	48.39			93	W000287161
4.0	450	160-180	64.44			90	W000287162
5.0	450	180-210	96.77			62	W000287163