OVERCORD

TOP FEATURES

- Excellent all positional operating characteristics, especially vertically-down
- Welding in the vertical-down position produces flat, slightly concave weld beads.
- Good gap bridging and easy striking and restriking.
- Used on mains transformers

CLASSIFICATION

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

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All positions

APPROVALS

LR	BV	DB	DNV	TÜV
+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si
0.08	0.5	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	0°C
AWS A5.1	AW	≥330	≥430	≥17	not specified	not specified
EN ISO 2560-A	AW	≥380	470-600	≥20	not specified	≥47
Typical values	AW	457	520	26	85	64

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-85
3.2 x 350	90-130
4.0 x 350	140-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	244	4.5	W000287110
3.2 x 350	CBOX	163	4.5	W000287111
4.0 x 350	CBOX	103	4.5	W000287112

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.