

OVERCORD E

TOP FEATURES

- Stable arc and very spattering loss
- The slag is self-releasing.
- Very good weldability on AC and DC- current.

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 42 0 R 12

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S
0.08	0.5	0.4	≤0.03	≤0.02

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	≥420	500-640	≥20	not specified	≥47
Typical values	AW	430	550	24	75	55

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
1.6 x 250	35-50
2.0 x 300	50-70
2.5 x 300	60-90
2.5 x 350	60-90
3.2 x 350	110-135
3.2 x 450	110-135
4.0 x 350	160-180
4.0 x 450	160-180
5.0 x 450	180-210

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
1.6 x 250	CBOH	250	1.5	W000380863
2.0 x 300	CBOH	161	1.9	W000380865
2.5 x 300	CBOX	237	3.8	W000380867
2.5 x 350	CBOX	230	4.5	W000287158
3.2 x 350	CBOX	141	4.5	W000287159
3.2 x 450	CBOX	139	5.8	W000287160
4.0 x 350	CBOX	93	4.5	W000287161
4.0 x 450	CBOX	90	5.8	W000287162

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.