

PRODUCT DATA SHEET

Oerlikon Overcord



Rutile-cellulosic type electrode for the welding of a large variety of components. It is particularly suitable for the welding of root runs in pipe, for tight joint preparations and for the welding of storage vessels and oil tanks. Overcord has excellent all-position weldability including vertical-up and down and is ideal for fillet welding in the vertical-down position. It has a deposition efficiency of 60%.

Re-drying Procedure

Provided that electrodes are stored in dry conditions, re-drying is not necessary.

Classifications

Standards

AWS/ASME SF	A 5.1	E6012
EN	2560	E35 A RC II

Electrode Marking

Overcord		
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Typical Chemical Analysis (All weld metal)

% Carbon	0,08	% Sulphur	0,03 max
% Manganese	0,5	% Phosphorous	0,03 max
% Silicon	0,3		

Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	>360 MPa
Tensile Strength	450 - 560 MPa
% Elongation on 5d	>22
Impact Strength at +20°C	>60 J
Impact Strength at 0°C	>50 J
Impact Strength at -20°C	>25 J

Packing Data (42 V OCV min)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Pieces per Carton (approx.)	Item Number
2,5	60 - 90	350	5,0	277	W111312
3,15	90 - 140	350	5,0	179	W111313
4,0	140 - 180	350	5,0	110	W111314
5,0	180 - 240	350	5,0	71	W111315

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