

## MMA Electrodes C-Mn and low-alloy steels

Medium-thick rutile-cellulosic general-purpose MMA electrode for structural steelwork, workshop and maintenance welding in all positions. Good gap bridging, easy striking and restriking. The slag is generally self-releasing, the weld beads are smooth and slightly concave, blending into the base plate without undercut. Used for welding galvanised steels, there is a tolerance to impurities in the welding zone. OVERCORD Z has a softer arc than OVERCORD.

Classification	
EN ISO	2560-A: E 38 0 RC 1 1
EN	499: E 38 0 RC 1 1
AWS	A5.1: E 6013

Approvals	Grade
ABS	2
BV	2
DB	●
DNV	2
GL	2
LRS	2
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si
0.08	0.5	0.3

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	0 °C
As Welded	≥ 380	470-600	≥ 22	≥ 60	≥ 47

### Materials

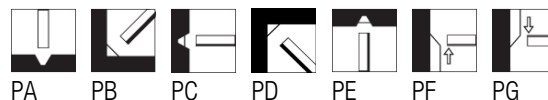
S(P)235 - S(P)355; GP240; GP280

### Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

### Current condition and welding position

AC; DC-



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
2.0	300	50-60	9.6			390	●
2.5	350	55-85	17.5	115	●	250	●
3.2	350	90-140	29.6	65	●	155	●
4.0	350	130-180	44.6	45	●	100	●