

MMA Electrodes C-Mn and low-alloy steels

OVERCORD R12 is a rutile coated MMA electrode for all positional welding. Easy to use and tolerant of dirty or poorly prepared base plates. Efficiency 100%.

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
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	0.6	0.4	≤ 0.03	≤ 0.03

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 380	470-580	≥ 20	≥ 47

Materials

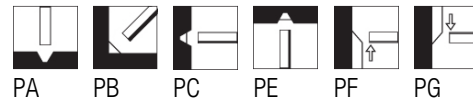
S(P)235 to S(P)355; GP240; GP280

Storage

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

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		SMPA	
				PC	Code	PC	Code
2.0	350	50-65	11.3	355	●		
2.5	350	75-95	17.3	250	●	38	●
3.2	350	95-125	26.9	155	●	24	●
3.2	450	95-125	35.0	155	●		
4.0	350	140-190	43.0	100	●		
4.0	450	140-190	55.4	100	●		
5.0	450	160-230	87.4	70	●		