

ETC PH48 OVERCORD R92



MMA Electrodes C-Mn and low-alloy steels

OVERCORD R92 is a rutile coated MMA electrode for welding in all positions. Excellent fusion and good bead aspect. Used with all types of welding equipment even with low OCV. Efficiency 100%.

Classification	
EN ISO	2560-A: E 35 0 RC 1 1
EN	499: E 35 0 RC 1 1
AWS	A5.1: E 6013

Approvals	Grade
BV	2Y

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	0.55	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	≥ 355	440-570	≥ 24	≥ 47

Materials

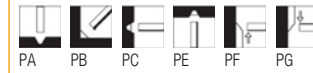
S(P)235 to S(P)355; GP240; GP280

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)	BOX	
				PC	Code
1.6	300	35-50	7.1		-
2.0	350	50-65	11.3	355	-
2.5	350	70-95	18.2	230	ETC PH4825
3.2	350	90-125	29.1	165	ETC PH4832
3.2	450	90-125	38.0	165	-
4.0	350	130-175	42.8	110	ETC PH4840
4.0	450	130-175	55.0	110	-
5.0	450	160-230	87.4	70	-

