ETC PH68 *OVERCORD*

MMA Electrodes
C-Mn and low-alloy steels

Medium-thick rutile-cellulosic coated MMA electrode for structural steelwork, workshop and maintenance applications, welding can be carried out with the same current setting in all positions. Excellent all positional operating characteristics, especially vertical down and the arc characteristic ensures reliable penetration. Welding in the vertical-down position produces flat, slightly concave weld beads. Good gap bridging and easy striking and restriking. Used on primer painted and slightly rusted parts, as there is a high tolerance to impurities. The strong and stable arc makes OVERCORD suitable for welding galvanised steel components. Used on mains transformers.

Classification	
EN ISO	2560-A: E 38 0 RC 11
EN	499: E 38 0 RC 11
AWS	A5.1: E 6013

Approvals	Grade
ABS	1 (P)
BV	1
DB	●
DNV	1
GL	1
LRS	1m
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)	BOX	
				PC	Code
2.0	250	50-60	7.8		-
2.5	350	60-85	16.2	275	ETC PH6825
3.2	350	90-130	28.0	160	ETC PH6832
3.2	450	120-140	41.8	139	-
4.0	350	140-180	43.0	105	ETC PH6840
4.0	450	170-190	64.5	90	-
5.0	350	180-240	67.5	70	ETC PH6850