

PRODUCT DATA SHEET

Oerlikon Supercord



Rutile-cellulosic type electrode for general assembly work, also for lighter gauge sheet. Highly suitable for sheet metal containers, storage vessels and oil tanks. Excellent all-position weldability including vertical-up and down. 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	E6013
EN	2560	E35 A R II
SABS	455	E4313 / 0415

Electrode Marking

Supercord		
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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 - 550 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	W111022
3,15	90 - 140	350	5,0	179	W111023
4,0	140 - 180	350	5,0	110	W111024
5,0	180 - 240	350	5,0	71	W111025

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