

OK Autrod 19.41

A continuous solid aluminium bronze electrode alloyed with Ni. OK Autrod 19.41 is used for overlay welding of steel and for welding of cast or wrought nickel-aluminium bronze materials. The alloy has very good resistance to seawater

Specifications

Classifications	EN ISO 24373 : CuAl8Ni2Fe2Mn2
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Alloy Type	Alloyed copper (Cu + 8 % Al + 2 % Ni)
Shielding Gas	I1, I2, I3 (EN 439)

Typical Wire Composition %

Mn	Si	Ni	Al	Cu	Zn	Fe
2	0.05	2	8.0	85.00	0.04	2.5

Typical Weld Metal Analysis %

Mn	Si	Ni	Al	Cu	Zn	Fe
2	0.05	2	8.0	85.00	0.04	2.5

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
150-320 A	1.2 mm (0.047 in.)	16-29 V	5.0-11.5 mm/min (197-453 in./min)