

OK Autrod 19.46

A continuous solid Cu-Mn-Al-electrode for weld cladding and joining of Cu-Al-alloys alloyed with Ni and Mn. Produces a wear-, corrosion- and sea water resistant layer on steel and cast iron. The alloy has a rather high resistance against erosion and cavitation.

Specifications

Classifications	SFA/AWS A5.7 : ER CuMnNiAl EN ISO 24373 : CuMn13Al8Fe3Ni2
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Alloy Type	Alloyed copper (Cu +13 % Mn + 7 % Al + 2 % Ni)
Shielding Gas	Inert gas (Ar, Ar/He-mixtures, He)

Typical Wire Composition %

Mn	Ni	Al	Fe
13	2	8	2.5

Typical Weld Metal Analysis %

Mn	Ni	Al	Fe
13	2	8	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)