

OK Autrod 19.12

A continuous solid copper wire for welding of oxygen free, pure copper and low alloyed copper. OK Autrod 19.12 is alloyed with tin, and has good flow properties. The weld is easily workable. For welding of large work pieces and heavy thickness preheating is recommended.

Specifications

Classifications	SFA/AWS A5.7 : ERCu EN ISO 24373 : CuSn1
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Alloy Type	Copper (Cu + 0.7 % Sn)
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Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	75 MPa	220 MPa	30 %

Typical Wire Composition %

Mn	Si	Cu	Fe
0.2	0.2	Bal	0.05

Welding Parameters

Amps	Wire Diameter	Volts	Wire Feed Speed
60-165 A	0.8 mm	13-17.5 V	4.0-13.0 mm/min
80-210 A	1.0 mm	12.5-18 V	4.0-12.0 mm/min
150-320 A	1.2 mm	16-29 V	5.0-11.5 mm/min