

OK Autrod 19.30

A continuous, solid copper wire, for welding of copper-zinc alloys, low-alloyed copper and for Mig brazing of zinc coated steel sheets. OK Autrod 19.30 is alloyed with silicon and manganese. The alloy is widely used in the automotive industry for Mig brazing of galvanised steel in car body production. The wire is also suitable for overlay welding of un- and low alloyed steels. Pulsed GMAW is recommended.

Specifications

Classifications	SFA/AWS A5.7 : ER CuSi-A EN ISO 24373 : CuSi3Mn1
Approvals	VdTÜV : 09147

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Alloyed copper (Cu + 3 % Si)
Shielding Gas	I1, I2, I3, M13 (EN439)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	130 MPa	350 MPa	40 %

Typical Wire Composition %

Mn	Si	Cu	Sn	Zn	Fe
0.9	3	96	0.01	0.05	0.05

Typical Weld Metal Analysis %

Mn	Si	P	Ni	Al	Sn	Pb	Fe
0.8	3	0.005	0.005	0.004	0	0.003	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
	1.6 mm		