

OK Autrod 19.21

A continuous, solid, copper wire for welding of copper-zinc alloys, low alloyed copper and Mig brazing of zinc coated steel. OK Autrod 19.21 has very good welding properties with low amount of spatter. The alloy is also used for overlay welding on low- and non alloyed steels and cast iron.

Specifications

Approvals	VdTÜV : 09739 (JC)
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Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Alloyed copper (Cu + 1.7 % Si - 1 % Mn - 0.2 % Sn)
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Shielding Gas	I1, I2, I3 (EN 439)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	90 MPa	280 MPa	40 %