

## OK Autrod 19.40

A continuous solid copper wire for welding of aluminium bronzes of the same type and over lay welding of un- and low alloyed steels. OK Autrod 19.40 is alloyed with aluminium and is recognised for high strength, good wear resistance and very good corrosion resistance against sea water. The alloy is also commonly used in the automotive industry for Mig brazing of galvanised steel in car body production.

### Specifications

<b>Classifications</b>	SFA/AWS A5.7 : ER CuAl-A1 EN ISO 24373 : S Cu 6100 (CuAl7)
------------------------	---

<b>Alloy Type</b>	Alloyed copper ( Cu + 8 % Al)
<b>Shielding Gas</b>	I1, I2, I3, M13 (EN439)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	175 MPa	420 MPa	40 %

### Typical Wire Composition %

Mn	Si	Al	Pb	Zn	Fe
0.3	0.1	7	0.01	0.1	0.4

### Typical Weld Metal Analysis %

Mn	Si	Al	Pb	Zn	Fe
0.2	0.05	8	0.003	0.05	0.1

### Recommended Welding Parameters

Current	Wire Diameter	Voltage	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		