

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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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	75 MPa (11 ksi)	220 MPa (32 ksi)	30 %

Typical Wire Composition %

Mn	Si	Cu	Fe
0.2	0.2	Bal	0.05

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
60-165 A	0.8 mm (0.030 in.)	13-17.5 V	4.0-13.0 mm/min (157-512 in./min)
80-210 A	1.0 mm (0.040 in.)	12.5-18 V	4.0-12.0 mm/min (157-472 in./min)
150-320 A	1.2 mm (0.047 in.)	16-29 V	5.0-11.5 mm/min (197-453 in./min)