

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.

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

Alloy Type	Alloyed copper (Cu + 3 % Si)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	130 MPa (19 ksi)	350 MPa (51 ksi)	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

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 m/min (157-512 in./min)
80-210 A	1.0 mm (0.040 in.)	12.5-18 V	4.0-12.0 m/min (157-472 in./min)
150-320 A	1.2 mm (0.047 in.)	16-29 V	5.0-11.5 m/min (197-453 in./min)
	1.6 mm (1/16 in.)		