



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 19.41

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REASON FOR ISSUE

Welding Parameters Revised

GENERAL

A continuous solid aluminium bronze electrode alloyed with Ni.

OK Autrod 19.41 is used for overlay welding of steel and for welding of cast or wrought nickel-aluminium bronze materials. The alloy has very good resistance to seawater

Shielding Gas: I1, I2, I3 (EN 439)

Alloy Type: Alloyed copper (Cu + 8 % Al + 2 % Ni)

CLASSIFICATIONS Wire Electrode

EN ISO 24373 CuAl8Ni2Fe2Mn2

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Si	0.05		0.2
Mn	2	1.0	2.5
Ni	2	0.5	3.0
Cu	85.00		
Al	8.0	7	9.5
Pb			0.02
Zn	0.04		0.2
Fe	2.5	0.5	2.5
		Comments: a) Other elements max 0.5 % b) Cu balance	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η		H		Feed			U	
	Min	Max		Nom	Nom	Min	Max	Min	Max	Min	Max	
\emptyset 1.2	150	320	15					5	11.5	16		29

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)