OK Autrod 19.30

A continuous, solid, copper wire for the GMAW joining of copper-zinc alloys and low-alloyed copper and for the GMAW brazing of zinc-coated steel sheets. OK Autrod 19.30 is alloyed with silicon and manganese and has good flow properties and wear resistance. The alloy is widely used in the joining of zinc-coated steel sheets in car body production, as well as for overlay welding on low- and non-alloyed steels and cast iron. Pulsed GMAW is recommended. OK Autrod 19.30 is normally welded with pure Ar as the shielding gas; however, for GMAW brazing, the addition of 1% O2 improves the brazing properties.

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

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	Alloyed copper (Cu + 3 % Si)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	130 MPa	350 MPa	40 %

Typical Wire Composition %

Mn	Si	Cu	Fe	Sn	Zn
0.9	3	96	0.05	0.01	0.05

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	60-165 A	13-17.5 V	4.0-13.0 m/min
1.0 mm	80-210 A	12.5-18 V	4.0-12.0 m/min
1.2 mm	150-320 A	16-29 V	5-11.5 m/min
1.6 mm	-	-	-

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