

OK Autrod 19.30

GMAW
ERCuSi-A

Description

A continuous, solid, copper wire for the GMA joining of copper-zinc alloys and low-alloyed copper and for the GMA 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 GMA is recommended. OK Autrod 19.30 is normally welded with pure Ar as the shielding gas; however, for GMA brazing, the addition of 1% O₂ improves the brazing properties.

Welding current

DC(+)

Classifications

SFA/AWS A5.7	ERCuSi-A
EN 14640	S Cu 6560 (CuSi3Mn1)

Wire composition

Si	Mn	Cu	Sn	Zn	Fe
3.4	1.1	>94.0	<0.2	<0.2	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	130
Tensile strength, MPa	350
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	25

Approvals

VdTÜV	09147
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