

## 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.

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	130 MPa ( 19 ksi )	350 MPa ( 51 ksi )	40 %

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

Typical Wire Composition %						
Mn	Si	Cu	Sn	Zn	Fe	
0.9	3	96	0.01	0.05	0.05	

Recommended Welding Parameters			
Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm ( 0.030 in. )	60-165 A	13-17.5 V	4.0-13.0 mm/min ( 157-512 in./min )
1.0 mm ( 0.040 in. )	80-210 A	12.5-18 V	4.0-12.0 mm/min ( 157-472 in./min )
1.2 mm ( 0.047 in. )	150-320 A	16-29 V	5.0-11.5 mm/min ( 197-453 in./min )
1.6 mm ( 1/16 in. )	-	-	-