

OK Autrod 19.40

A continuous, solid, copper wire for the GMAW joining of aluminium bronzes. OK Autrod 19.40 is alloyed with aluminium and is recognised for its high strength, good wear resistance and very good corrosion resistance, particularly in salt water. The alloy is widely used for joining corrosion-resistant pipes made of aluminium bronze or other special brass alloys. Other common applications include the overlay welding of bearings, ships propellers and rails. OK Autrod 19.40 is normally welded with pure Ar as the shielding gas.

Classifications Wire Electrode:	SFA/AWS A5.7:ERCuAl-A1, EN ISO 24373:S Cu 6100 (CuAl7)
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Alloy Type:	Alloyed copper (Cu + 8 % Al)
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As welded	175 MPa	420 MPa	40 %

Typical Wire Composition %						
Mn	Si	Al	Cu	Fe	Pb	Zn
0.3	0.1	7	Bal	0.4	0.01	0.1

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	5.0-11.5 m/min