

OK Autrod 19.12

A continuous, solid, copper wire for the GMAW joining of oxygen-free, pure copper and low-alloyed copper. OK Autrod 19.12 is alloyed with tin and has good flow properties. OK Autrod 19.12 is normally welded with pure Ar as the shielding gas.

Classifications Wire Electrode:	SFA/AWS A5.7:ERCu, EN ISO 24373:CuSn1
Approvals:	NAKS/HAKC 1.2MM

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

Alloy Type:	Copper (Cu + 0.7 % Sn)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	75 MPa	220 MPa	30 %

Typical Wire Composition %

Mn	Si	Cu	Fe
0.2	0.2	Bal	0.05

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	60-165 A	13-17.5 V	4-13 m/min
1.0 mm	80-210 A	12.5-18 V	4-12 m/min
1.2 mm	150-320 A	16-29 V	5-11.5 m/min