



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

# OK Autrod 19.12

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## REASON FOR ISSUE

Approval, classification and chemical composition update

## GENERAL

A continuous solid copper wire for welding of oxygen free, pure copper and low alloyed copper.  
OK Autrod 19.12 is alloyed with tin, and has good flow properties. The weld is easily workable. For welding of large work pieces and heavy thickness preheating is recommended.

**Alloy Type:** Copper (Cu + 0.7 % Sn)

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.7      ERCu  
EN ISO 24373      CuSn1

## APPROVALS

NAKS/HAKC

## CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
Si		0.50
Mn		0.50
P		0.15
Cu	98.0	
Al		0.01
Sn		1.0
Pb		0.01
As		0.05
Fe		0.05
Ni+Co		0.3
Others tot		0.5

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Typ
Rp0.2 (MPa)		75
Rm (MPa)		220
A4-A5 (%)		30