



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 19.30

Prepared by MALI	Qualified by Tero Tolonen	Approved by Michael Spieß	Reg no EN006213	Cancelling EN002925	Reg date 2013-09-13	Page 1 (2)
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REASON FOR ISSUE

Update of classification and chemical composition.

GENERAL

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.

Shielding Gas: I1, I2, I3, M13 (EN439)

Alloy Type: Alloyed copper (Cu + 3 % Si)

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.7 ERCuSi-A
EN ISO 24373 CuSi3Mn1

APPROVALS

VdTÜV 09147

CHEMICAL COMPOSITION

	All Weld Metal (%)		Wire/Strip (%)	
	Nom	Min	Max	
Si	3	2.8	4.0	
Mn	0.8	0.5	1.5	
P	0.005		0.05	
Ni	0.005			
Cu		94.0		
Al	0.004		0.02	
Sn	0		0.2	
Pb	0.003		0.02	
Zn			0.4	
Fe	0.05		0.5	
Ni+Co			0.10	
Others tot			0.5	

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Typ
Rp0.2 (MPa)	130	
Rm (MPa)	350	
A4-A5 (%)	40	

Comments:

Hardness: Typical 90 HB.



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U Max
	Min	Max			Min	Max	Min	Max	Min	
0.8	60	165	15				4.0	13.0	13	17.5
1.0	80	210	15				4.0	12.0	12.5	18
1.2	150	320	15				5	11.5	16	29
1.6										

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)