



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

# OK Autrod 19.41

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## REASON FOR ISSUE

Classifications and chemical analysis updated

## GENERAL

A continuous solid aluminium bronze electrode alloyed with Ni.

OK Autrod 19.41 is used for overlay welding of steel and for welding of cast or wrought nickel-aluminium bronze materials. The alloy has very good resistance to seawater

**Shielding Gas:** I1, I2, I3 (EN 439)

**Alloy Type:** Alloyed copper (Cu + 8 % Al + 2 % Ni)

## CLASSIFICATIONS Wire Electrode

EN ISO 24373      CuAl8Ni2Fe2Mn2

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Si	0.05		0.2
Mn	2	1.0	2.5
Ni	2	0.5	3.0
Cu	85.00		
Al	8.0	7	9.5
Pb			0.02
Zn	0.04		0.2
Fe	2.5	0.5	2.5

Comments:  
a) Other elements max 0.5 % b)  
Cu balance

## ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$		H		Feed			U	
	$\emptyset$	Min		Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2		0	0	12		0	0	0	0	0		0

**W** = Gas consumption (l / min)

**$\eta$**  = Recovery, g weld metal / 100g wire (%)

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

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)