Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 19.46

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REASON FOR ISSUE

Welding Parameters Revised

GENERAL

A continuous solid Cu-Mn-Al-electrode for weld cladding and joining of Cu-Al-alloys alloye with Ni and Mn. Produces a wear-, corrosion- and sea water resistant layer on steel and cast iron. The alloy has a rather high resistance against erosion and cavitation.

Shielding Gas: Inert gas (Ar, Ar/He-mixtures, He)

Alloy Type: Alloyed copper (Cu +13 % Mn + 7 % Al + 2 % Ni)

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.7	ERCuMnNiAl
EN ISO 24373	CuMn13Al8Fe3Ni2

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Si			0.1
Mn	13	11.0	14.0
Ni	2	1.5	3.0
Cu			
Al	8	7	8.5
Pb			0.02
Zn			0.15
Fe	2.5	2.0	4.0
	Comments: a) Cu rest	Comments: a) Other elements max 0.5 % b) Cu balance	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	150	320	15				5	11.5	16	29

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)

OTHER DATA

Preheating is not usually necessary. Keep interpass temperature below 150 °C.