

OK Autrod 19.40

A continuous solid copper wire for welding of aluminium bronzes of the same type and over lay welding of un- and low alloyed steels. OK Autrod 19.40 is alloyed with aluminium and is recognised for high strength, good wear resistance and very good corrosion resistance against sea water. The alloy is also commonly used in the automotive industry for Mig brazing of galvanised steel in car body production.

Классификации	AWS A5.7 : ERCuAl-A1 EN ISO 24373 : S Cu 6100 (CuAl7)
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Тип сплава	Alloyed copper (Cu + 8 % Al)
Защитный газ	I1, I2, I3, M13 (EN439)

Хим. состав наплавленного металла

Mn	Si	Al	Fe	Pb	Zn
0.2	0.05	8	0.1	0.003	0.05

Хим. состав проволоки

Mn	Si	Al	Fe	Pb	Zn
0.3	0.1	7	0.4	0.01	0.1

Данные наплавки

Диаметр проволоки	Current	Voltage	Wire Feed Speed
0.8 mm	60-165 A	13-17.5 V	4.0-13.0 m/min
1.0 mm	80-210 A	12.5-18 V	4.0-12.0 m/min
1.2 mm	150-320 A	16-29 V	5.0-11.5 m/min
1.6 mm	-	-	-