

# OK Autrod 19.12

GMAW  
ERCu

## Description

A continuous, solid, copper wire for the GMA joining of oxygen-free, pure copper and low-alloyed copper. OK Autrod 19.12 is alloyed with tin and has good flow properties. OK Autrod 19.12 is normally welded with pure Ar as the shielding gas.

## Welding current

DC(+)

## Classifications

SFA/AWS A5.7	ERCu
EN 14640	S Cu 1898 (CuSn1)

## Wire composition

Si	Mn	Cu	Sn
0.3	0.3	>98.0	0.8

## Typical mech. properties all weld metal

Yield stress, MPa	75
Tensile strength, MPa	220
Elongation, %	30

## Charpy V

Test temps, °C	Impact values, J
+20	75
-20	40