

OK Tigrod 19.30 GTAW

ERCuSi-A

Description

Bare copper wire for the GTA joining of copper-zinc alloys and low-alloyed copper alloys. OK Tigrod 19.30 is alloyed with silicon and manganese and has good flow properties and wear resistance. The alloy is widely used in the joining of zinc-coated steel sheets and for joining low- and non-alloyed steels and cast iron. OK Tigrod 19.30 is normally welded with pure Ar as the shielding gas.

Welding current

DC(-)

Classifications

SFA/AWS A5.7	ERCuSi-A
EN 14640	S Cu 6560 (CuSi3Mn1)

Wire composition

Si	Mn	Cu	Sn	Zn	Fe
3.4	1.1	>94.0	<0.2	<0.2	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	150
Tensile strength, MPa	350
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	30

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5
2.0	1000	5
2.4	1000	5