

OK Autrod 19.40 GMAW

ERCuAl-A1

Description

A continuous, solid, copper wire for the GMA joining of aluminium bronzes.

OK Autrod 19.40 is alloyed with aluminium and is recognised for its high strength, good wear resistance and very good corrosion resistance, particularly in salt water. The alloy is widely used for joining corrosion-resistant pipes made of aluminium bronze or other special brass alloys. Other common applications include the overlay welding of bearings, ship's propellers and rails. OK Autrod 19.40 is normally welded with pure Ar as the shielding gas.

Welding current

DC(+)

Classifications

SFA/AWS A5.7	ERCuAl-A1
EN 14640	S Cu 6100 (CuAl8)

Wire composition

Si	Mn	Al	Fe	Cu
<0.1	<0.5	7.8	<0.5	bal.

Typical mech. properties all weld metal

Yield stress, MPa	175
Tensile strength, MPa	420
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	70