

# OK Tigrod 19.12

GTAW  
ERCu

## Description

Bare copper wire for the GTA joining of oxygen-free, pure copper and low-alloyed copper. OK Tigrod 19.12 is alloyed with tin and has good flow properties. Preheating is recommended when welding large pieces. OK Tigrod 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

## Packing data

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

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