

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 |

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