

OK TIGROD 19.30

A Si-Mn alloyed copper solid rod for GTAW

Classification AWS A5.7: ERCuSi-A

DESCRIPTION

OK TIGROD 19.30 is a silicon-manganese alloyed copper solid rod, for welding of copper-silicon, copper-zinc and low alloyed copper alloys. OK TIGROD 19.30 has good flow properties. The alloy is widely used in the joining of zinc-coated steel sheets.

WELDING CURRENT: DC-

SHIELDING GAS: Ar or He or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	3.40	YS (N/mm ²)	150
Mn	1.10	UTS (N/mm ²)	350
Cu	>94	Elongation (%)	40
Sn	<0.20		
Zn	<0.20		
Fe	<0.30		

PACKING DATA

Size (mm)	Length (mm)	Packing (5 Kg.)
2.0	1000	✓
3.2	1000	✓

PACKING: The rods are packed in tubes weighing 5 kg.