ESAB MW1

A Cu coated solid wire for GMAW

Classification AWS A5.18: ER70S-6
EN ISO 14341-A: G 3Si1

DESCRIPTION

ESAB MW1 is a copper coated, Mn-Si alloyed solid wire for GMAW of non alloyed steels, used in general construc-tion, automotives, ship building and pressure vessel fabrication. The wire has a carefully controlled wire chemistry and a unique surface technology providing superior weld metal quality at high wire feed speeds and at high welding currents.

WELDING CURRENT: DC+

APPROVALS: ABS, DNV, IBR, IRS, LRS, MMD, MN Dastur & NPC

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm²)	450
Si	0.85	UTS (N/mm²)	560
Mn	1.45	Elongation (%)	24
Cu	0.25	Impact (CVN) @ -30ºC (Joules)	50

CURRENT RANGE & PACKING DATA

Size (mm)	Current (Amp)	Voltage (V)	Packing in Kg.				
			12.5	15.0	17.5	100	250
0.8	60-220	17-25	✓	✓	×	✓	×
1.2	90-330	18-30	×	✓	✓	✓	✓
1.6	120-440	20-36	✓	×	×	×	✓
2.0	150-550	21-41	✓	×	×	×	×

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing12.5/15.0/17.5 kg or Marathon Pac weighing 100/250 kg or Bobbins weighing 200 kg.

OK ARISTOROD 12.50

A non Cu coated solid wire for GMAW

Classification AWS A5.18: ER70S-6
EN ISO 14341-A: G 3Si1

DESCRIPTION

OK ARISTOROD 12.50 is a non copper coated Mn-Si alloyed solid wire for the GMAW of unalloyed steels, used in general construction, automotive components, pressure vessel fabrication and shipbuilding. OK ARISTOROD 12.50 is treated with ESAB's unique Advanced Surface Characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristic features include excellent start properties; trouble-free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire. OK ARISTOROD 12.50 is available in the unique ESAB octagonal Marathon Pac, which is excellent for mechanised welding applications.

APPROVALS: ABS, BV, CE, DB, DNV, LR, PRS, RS & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm²)	470
Si	0.90	UTS (N/mm²)	560
Mn	1.50	Elongation (%)	26
		Impact (CVN) @ -30ºC (Joules)	70

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-200	18-24
0.9	70-250	18-26
1.0	80-300	18-32
1.2	120-380	18-35
1.4	150-420	22-36
1.6	225-550	28-38

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15/18 kg or Marathon Pac weighing 250/475 kg.

OK ARISTOROD 13.09

A non Cu coated 0.5Mo alloyed solid wire for GMAW

Classification AWS A5.28: ER80S-G

DESCRIPTION

OK ARISTOROD 13.09 is a non copper coated 0.5Mo alloyed solid wire for the GMAW of creep-resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to 500ºC. The wire is suitable for operating at high currents with maintained disturbance free wire feeding giving a stable arc with a low amount of spatter. OK ARISTOROD 13.09 is available in the unique ESAB octagonal Marathon Pac, which is excellent for mechanised welding applications.

APPROVALS: CE, DB, DNV & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm²)	430
Si	0.60	UTS (N/mm²)	550
Mn	1.10	Elongation (%)	26
Mo	0.50	Impact (CVN)	
		@ +20ºC (Joules)	150
		@ -20ºC (Joules)	90
		@ -40ºC (Joules)	70

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	40-170	16-22
1.0	80-280	18-28
1.2	120-350	20-33
1.6	225-480	26-38

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15/18 kg or select sizes in Marathon Pac weighing 250 kg.

OK AUTROD 13.14

A Cu coated low alloyed solid wire for GMAW of HSLA steels

Classification AWS A5.28: ER90S-D2

DESCRIPTION

OK AUTROD 13.14 is a copper coated low alloyed wire for GMAW of HSLA steels. It is used for fabrication of tractor cylinder, automobile components and wagons. The wire is designed to produce excellent beads of radiographic quality in all positions. One of the significant applications of OK AUTROD 13.14 is of welding 'CONCOR' wagons of the Indian Railways

APPROVALS: RDSO

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm²)	580
Si	0.60	UTS (N/mm²)	690
Mn	2.00	Elongation (%)	24
Mo	0.45	Impact (CVN)	
Cu	0.25	@ -30ºC (Joules)	45

CURRENT RANGE & PACKING DATA

Size (mm)	Current (Amp)	Voltage (V)	Packing in Kg.	
			12.5	15.0
1.2	80-280	18-28	✓	✓
1.6	120-360	20-34	✓	×

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK ARISTOROD 13.16

A non Cu coated 1.3Cr-0.5Mo alloyed solid wire for GMAW of creep resistant steels

Classification AWS A5.28: ER80S-B2

DESCRIPTION

OK ARISTOROD 13.16 is a non copper coated chromium-molybdenum alloyed (1.3Cr-0.5Mo), solid wire for GMAW of creep resistant steels like SA387 Grade 11, A335 Grade P11 or similar materials. OK ARISTOROD 13.16 is a high purity wire with a guaranteed Bruscato factor X<15. It is treated with ESAB´s unique advanced surface characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristics features include excellent start properties; trouble free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm²)	490
Si	0.60	UTS (N/mm²)	580
Mn	0.60	Elongation (%)	21
Cr	1.35		
Mo	0.50		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.2	120-350	20-33

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 18 kg or Marathon Pac weighing 250 kg.

OK AUTROD 13.17

A Cu coated 2.5Cr-1Mo alloyed solid wire for GMAW of creep resistant steels

Classification AWS A5.28: ER90S-B3

DESCRIPTION

OK AUTROD 13.17 is a copper coated chromium-molybdenum alloyed (2.5Cr-1Mo), solid wire for GMAW of creep resistant steels like SA387 Grade 22, A335 Grade P22 or similar materials. The wire has high purity chemistry with a guaranteed Bruscato factor X < 15.

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2 or Ar/1-5O_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.09	YS (N/mm²)	590
Si	0.60	UTS (N/mm²)	720
Mn	0.60	Elongation (%)	22
Cr	2.50	Impact (CVN)	
Mo	1.00	@ -40ºC (Joules)	50
Cu	0.25		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	80-280	18-28
1.2	120-350	20-33

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15 kg.

OK AUTROD 13.28

A Cu coated 2.4Ni alloyed solid wire for GMAW of low alloyed and low temperature steels

Classification AWS A5.28: ER80S-Ni2

DESCRIPTION

OK AUTROD 13.28 is a copper coated 2.4Ni alloyed, solid wire for GMAW of low-alloyed and low temperature steels in applications such as vessels, pipes and offshore industry with a minimum yield strength less than 470 MPa. The wire provides good impact toughness down to -60°C.

APPROVALS: CE, DNV, NAKS & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO_2 or 80%Ar/20%CO_2 or Ar/1-5O_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm²)	540
Si	0.60	UTS (N/mm²)	630
Mn	1.10	Elongation (%)	29
Ni	2.40	Impact (CVN)	
Mo	0.15	@ -60ºC (Joules)	50
Cu	0.25		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	80-170	16-22
1.0	80-280	18-28
1.2	120-350	20-33

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15 kg.

OK ARISTOROD 69

A non Cu coated Cr-Ni-Mo alloyed solid wire for GMAW of high tensile strength steels

Classification AWS A5.28: ER110S-G
EN ISO 16834-A: G Mn3Ni1CrMo

DESCRIPTION

OK ARISTOROD 69 is a non copper coated 0.3Cr-1.4Ni-0.25Mo alloyed, solid wire for the GMAW of high strength steels with low-temperature impact toughness requirements. OK ARISTOROD 69 is treated with ESAB's unique Ad-vanced Surface Characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristic features include excellent start properties; trouble-free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire. OK ARISTOROD 69 is available in the unique ESAB octagonal Marathon Pac, which is excellent for mechanised welding applications.

APPROVALS: CE, DB & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: 80%Ar/20%CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm²)	730
Si	0.60	UTS (N/mm²)	800
Mn	1.70	Elongation (%)	19
Cr	0.30	Impact (CVN)	
Ni	1.40	@ -20ºC (Joules)	70
Mo	0.25	@ -40ºC (Joules)	55

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	80-280	18-28
1.0	80-280	18-28
1.2	120-350	20-33

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15/18 kg or select sizes in Marathon Pac weighing 250 kg.

OK AUTROD 16.10

An extra low carbon stainless steel solid wire for GMAW of 18Cr-8Ni type steels

Classification AWS A5.9: ER308L

DESCRIPTION

A corrosion resistant, chromium-nickel alloyed solid wire for welding austenitic stainless alloys of 18Cr-8Ni type. OK AUTROD 16.10 has good general corrosion resistance. The alloy has a low carbon content which makes it particularly suitable to the applications, where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers.

APPROVALS: NPC

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	420
Si	0.45	UTS (N/mm²)	590
Mn	1.70	Elongation (%)	36
Cr	20.00	Impact (CVN)	
Ni	9.80	@ -196ºC (Joules)	50

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28
1.6	100-380	19-33

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.11

A Nb stabilized 20Cr-10Ni stainless steel solid wire for GMAW

Classification AWS A5.9: ER347

DESCRIPTION

A corrosion-resistant, chromium-nickel alloyed solid wire for welding stabilized austenitic chromium-nickel alloys of 18Cr-8Ni type. OK AUTROD 16.11 has good general corrosion resistance. The alloy is stabilized with niobium to improve resistance to the intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures.

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	400
Si	0.40	UTS (N/mm²)	600
Mn	1.50	Elongation (%)	35
Cr	19.50	Impact (CVN)	
Ni	9.50	@ +20ºC (Joules)	100
Nb	0.40		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.13

An austenitic stainless steel solid wire for GMAW of 25Cr-20Ni type steels

Classification AWS A5.9: ER310

DESCRIPTION

A corrosion-resistant, chromium-nickel alloyed solid wire for welding heat-resistant austenitic stainless steels of 25Cr-20Ni type. OK AUTROD 16.13 has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. Common applications include indus-trial furnaces, boiler parts and heat exchangers.

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.09	YS (N/mm²)	310
Si	0.40	UTS (N/mm²)	510
Mn	1.60	Elongation (%)	32
Cr	26.00	Impact (CVN)	
Ni	20.50	@ +20ºC (Joules)	120

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.2	80-280	19-28

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.30

An extra low carbon stainless steel solid wire for GMAW of 18Cr-12Ni-2.5Mo type steels

Classification AWS A5.9: ER316L

DESCRIPTION

A corrosion resistant, chromium-nickel-molybdenum alloyed solid wire for welding austenitic stainless alloys of the 18Cr-8Ni and 18Cr-12Ni-2.5Mo types. The alloy has very good resistance to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly suitable to the applications, where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structures.

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	430
Si	0.40	UTS (N/mm²)	620
Mn	1.70	Elongation (%)	35
Cr	18.50	Impact (CVN)	
Ni	11.80	@ -196ºC (Joules)	50
Mo	2.70		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28
1.6	100-380	19-33

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.53

An extra low carbon 24Cr-13Ni stainless steel solid wire for GMAW

Classification AWS A5.9: ER309L

DESCRIPTION

A corrosion resistant, chromium-nickel alloyed solid wire for joining stainless steels to non-alloy or low-alloy steels and for welding austenitic stainless alloys of the 24Cr-13Ni types. The alloy is also used for welding buffer layers on C-Mn steels.

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	420
Si	0.40	UTS (N/mm²)	600
Mn	1.70	Elongation (%)	37
Cr	23.50	Impact (CVN)	
Ni	12.50	@ -60ºC (Joules)	80

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28
1.6	100-380	19-33

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 1100

A soft aluminium solid wire for GMAW

Classification AWS A5.10: ER1100

DESCRIPTION

OK AUTROD 1100 is highly resistant to chemical attack and weathering. It is a relatively soft alloy that is very formable and is used extensively in thin gauge and foil products. It has good welding characteristics. A desirable characteristic of the alloy is bright finish obtained by anodising. Non-heat treatable.

APPROVALS: CWB

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Mn	<0.05	YS (N/mm²)	30
Cu	0.13	UTS (N/mm²)	75
Al	>99.00	Elongation (%)	35
Zn	<0.10		
Si+Fe	<0.95		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	140-260	20-29
1.2	140-260	20-29
1.6	190-350	25-30

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg.

OK AUTROD 4043

A Si alloyed general purpose aluminium solid wire for GMAW

Classification AWS A5.10: ER4043

DESCRIPTION

OK AUTROD 4043 is one of the most widely used welding and brazing alloys and can be classified as a general purpose filler alloy. The silicon additions result in improved fluidity (wetting action) to make the alloy a preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright and almost smut free welds. Not recommended for anodizing. Non-heat treatable.

APPROVALS: CE, CWB, DB & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	5.00	YS (N/mm²)	55
Mn	<0.05	UTS (N/mm²)	165
Cu	<0.10	Elongation (%)	18
Ti	<0.15		
Zn	<0.10		
Fe	<0.60		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-170	13-24
0.9	60-170	13-24
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.0	280-400	26-31
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 5183

A Mg-Mn alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5183

DESCRIPTION

OK AUTROD 5183 is designed to provide the highest possible strength in the as welded condition of alloy AA 5083 and similar high magnesium alloys. The alloy is typically used in marine and structural applications where high strength, high fracture toughness for impact resistance and exposure to corrosive elements are important. The alloy is not recommended for elevated temperature applications due to its susceptibility to stress corrosion cracking. The alloy is non-heat treatable.

APPROVALS: ABS, BV, CE, Class NK, CWB, DB, DNV, GL, LR & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.40	YS (N/mm²)	140
Mn	0.80	UTS (N/mm²)	290
Cr	0.15	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	<0.15	@ +200C (Joules)	30
Zn	<0.25		
Fe	<0.40		
Mg	4.80		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 5356

A Mg alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5356

DESCRIPTION

OK AUTROD 5356 is the most widely used welding alloy and can be classified as a general purpose type filler alloy. OK AUTROD 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with OK AUTROD 5356, with weld pool chemistry greater than 3% Mg and service temperatures in excess of 65°C is susceptible to stress corrosion cracking. The alloy is non-heat treatable.

APPROVALS: ABS, BV, CE, CWB, DB, DNV, GL, LR, RINA & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm²)	120
Mn	0.15	UTS (N/mm²)	265
Cr	0.13	Elongation (%)	26
Cu	<0.10		
Ti	0.11		
Zn	<0.10		
Fe	<0.40		
Mg	5.00		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-170	13-24
0.9	60-170	13-24
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 5556A

A Mg-Mn alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5556

DESCRIPTION

OK AUTROD 5556A is a continuous solid wire suitable for welding of aluminium alloys (approx. up to 5 % Mg) that are not age-hardenable and alloys where a higher tensile strength is required. The corrosion resistance in marine atmosphere is high.

APPROVALS: CE & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or He or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm²)	145
Mn	0.80	UTS (N/mm²)	295
Cr	0.13	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	0.13	@ +200C (Joules)	25
Zn	<0.20		
Fe	<0.40		
Mg	5.30		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 19.30

A Si-Mn alloyed copper solid wire for GMA welding and GMA brazing

Classification AWS A5.7: ERCuSi-A

DESCRIPTION

OK AUTROD 19.30 is a silicon-manganese alloyed copper solid wire, for welding of copper-zinc alloys & low alloyed copper and for GMA brazing of zinc coated steel sheets. OK AUTROD 19.30 has good flow properties. The alloy is widely used in the automotive industry for GMA brazing of galvanised steel in car body production. The wire is also suitable for overlay welding of un-alloyed and low alloyed steels.

APPROVALS: VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or He or Ar/He or Ar/O_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	3.40	YS (N/mm²)	130
Mn	1.10	UTS (N/mm²)	350
Cu	>94	Elongation (%)	40
Sn	<0.20		
Zn	<0.20		
Fe	<0.30		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-165	13-17.5
1.0	80-210	12.5-18
1.2	150-320	16-29
1.6	170-350	18 - 31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 15 kg or select sizes in Marathon Pac weighing 200 kg.

OK AUTROD 19.40

An Al alloyed copper solid wire for GMAW of aluminium brozes

Classification AWS A5.7: ERCuAl-A1

DESCRIPTION

OK AUTROD 19.40 is aluminium alloyed copper solid wire for welding of aluminium bronzes of the same type and over lay welding of un-alloyed and low alloyed steels. The alloy is recognized for high strength, good wear resistance and very good corrosion resistance particularly against sea 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.

WELDING CURRENT: DC+

SHIELDING GAS: Ar or He or Ar/He or Ar/O_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.10	YS (N/mm²)	175
Mn	<0.50	UTS (N/mm²)	420
Cu	bal.	Elongation (%)	40
Al	7.80		
Zn	<0.10		
Fe	<0.50		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-165	13-17.5
1.0	80-210	12.5-18
1.2	150-320	16-29
1.6	170-350	18 - 31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 15 kg or select sizes in Marathon Pac weighing 200 kg.