# OK Tigrod 19.12

A continuous, solid, Cu-Ni wire for welding similar alloys like 90Cu10Ni, 80Cu20Ni and 70Cu30Ni alloys. The addition of nickel strengthens the weld metal and improves the corrosion resistance, particularly in the case of salt water. The alloy is used for the overlay welding of steels and is widely used for welding Cu-Ni components for desalination plants.

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|---|---|
| **Classifications Wire Electrode:** | SFA/AWS A5.7:ERCu, EN ISO 24373:CuSn1 |

| | |
|---|---|
| **Alloy Type:** | Copper (Cu + 0.7 % Sn) |

| Typical Tensile Properties | | | |
|---|---|---|---|
| **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** |
| As welded | 75 MPa | 220 MPa | 30 % |

| Typical Wire Composition % | | | |
|---|---|---|---|
| **Mn** | **Si** | **Cu** | **Fe** |
| 0.2 | 0.2 | Bal | 0.05 |

# OK Tigrod 19.30

Bare copper wire for the GTAW 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 andfor joining low- and non-alloyed steels and cast iron. OK Tigrod 19.30 is normally welded with pure Ar as the shielding gas.

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|---|---|
| **Classifications Wire Electrode:** | SFA/AWS A5.7:ERCuSi-A, EN ISO 24373:CuSi3Mn1 |

| | |
|---|---|
| **Alloy Type:** | Alloyed copper (Cu + 3 % Si ) |

| Typical Tensile Properties | | | |
|---|---|---|---|
| **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** |
| As welded | 150 MPa | 350 MPa | 40 % |

| Typical Wire Composition % | | | | | |
|---|---|---|---|---|---|
| **Mn** | **Si** | **Cu** | **Fe** | **Sn** | **Zn** |
| 0.9 | 3 | 96 | 0.05 | 0.01 | 0.05 |