




TIG/MIG SOLID TITANIUM WELDING WIRES/RODS



ERTi-7

American Welding Society

Type:	Solid drawn Titanium Grade 7 welding wire
Applications:	Grade 7 has the same mechanical properties as Grade 2. The 0.12 wt% palladium addition improves corrosion performance under mildly reducing conditions or where crevice or under-deposit corrosion is a problem. ERTi-7 can be considered for welding Grade 2 or 16 where improved corrosion performance is desired.
Properties:	The weld deposit is ductile and offers excellent corrosion resistance in oxidizing environments. The unique combination of mechanical strength and corrosion resistance makes the alloy a preferred choice in many applications to prevent or solve problems. The wire is cleaned in a very special way to obtain porosity free and a ductile weld deposit.
Classification:	AWS A 5.16: ER Ti 7 UNS: R52401 EN ISO 24034:STi-2401 DIN: W.Nr. 3.7235 DIN 1737:
Suitable for:	Titanium grade 7, grade 2, grade 16.
Welding Positions:	

WELD DEPOSIT WEIGHT %

C	O	N	H	Fe	Al	V	Pd	Mo	Ni
<0.03	0.08-0.16	<0.015	<0.008	<0.12	-	-	0.12-0.25	-	-

MECHANICAL PROPERTIES

Heat Treatment	RP 0.2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc/HV
				-20°C	-40°C	-60°C	
as welded	275	400	20	-	-	-	-

WELDING PARAMETERS/PACKING

Welding Parameters			Packing
Dia. (mm)	Length (mm)	Current (A)	kg/tube
1.0	1000		5
1.2	1000		5
1.6	1000		5
2.0	1000		5
2.4	1000		5
3.0	1000		5

Note: Also available as spooled wire :0.8 mm, 1.0 mm and 1.2 mm (D-100 / D-200 / D-300)