




TIG/MIG SOLID TITANIUM WELDING WIRES/RODS



ERTi-2

American Welding Society

Type:	Solid Titanium Welding Wire Grade 2
Applications:	ER Ti-2 is developed for welding Titanium grade 1, 2, 3 and 4. This alloy finds his applications in chemical industry and offers excellent Weldability.
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 prefernd 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 2 EN ISO 24034: S Ti 0120 (Ti 99,6) DIN: W.Nr. 3.7036 DIN 1737: SG Ti 2
Suitable for:	Titanium grade 1, 2, 3 and 4.
Welding Positions:	

WELD DEPOSIT WEIGHT %

C	O	N	H	Fe	Al	V	Pd	Mo	Ni
<0.03	0.03-0.10	<0.012	<0.005	<0.08	-	-	-	-	-

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	250	320	--	-	-	-	-

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)