CEWELD®

ER Ti-5

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid Titanium based welding wire (Grade 5) with extreme high strenght.
APPLICATIONS	Aerospace, marine, chemical plants, process plants, power generation, oil and gas extraction, medical and sports.
PROPERTIES	Excelent weldability, and can be heat treated to a higher strength or toughness. Grade 5 is used in aircraft components such as landing gear, wing spars, and compressor blades. Its corrosion resistance is generally comparable to Grade 2 and it is often used in corrosion service where higher strength is required, particularly in shafts, high strength bolting, and keys. The weld deposit is ductile and offers excellent corrosion resistance in oxidizing environments. The unique combination of mechanical strenght and corrosion resistance makes the alloy a prefered choice in many applications to prefend 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 5 EN ISO 24034: STi-6402c DIN: W.Nr. 3.7165 DIN 1737:
SUITABLE FOR	Titanium grade 5, UNS R56400, AMS 4954
APPROVALS	CE approved
WELDING POSITIONS:	

FILLER METAL ANALYSIS %

C	O	N	H	Fe	Al	V
<0.05	0.12-0.20	<0.03	<0.015	<0.22	5.5-6.7	3.5-4.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
	>890	>810					

WELDING PARAMETERS / PACKING

Welding Parameters			Packing
D (mm)	Length (mm)	Current (A)	kg / tube
1.6	1000		5
2.4	1000		5
3.2	1000		5

REDRYING TEMPERATURE	not required
NOTE	Also available as spooled wire :0.8 mm, 1.0 mm and 1.2 mm (D-100 / D-200 / D-300)