

ER Ti-7

CATEGORY GMAW-GTAW Solid wires

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

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD METAL WEIGHT %

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
as welded	275	400	20				

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing kg / tube
	Length (mm)	Current (A)	
1.6	1000		5
2.0	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)