BÖHLER ER Ti 2-IG

TIG rod, Titanium

Classifications

EN ISO 24034	AWS A5.16	
S Ti 0120 (Ti99,6)	ERTi-2	

Characteristics and typical fields of application

GTAW rod for welding pure Titanium and Titanium alloys with similar chemical composition. Titanium can be tungsten arc welded employing techniques similar to those used for welding of stainless steel. However, Titanium requires a greater cleanliness and the use of auxiliary gas shielding to protect the molten puddle and cooling weld zone from atmospheric contamination.

Base materials

Pure Titanium and Titanium alloys with a similar composition.
ASTM Grade 1-4
UNS R50400H

Typical analysis of the TIG rods (wt.-%)

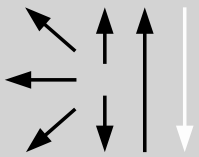
	C	Ti	Fe	O	H	N
wt-%	< 0.03	bal.	< 0.12	0.10	< 0.008	< 0.015

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	**295***	**500***	**42***	**76***

u untreated, as welded – shielding gas 100 % Argon
* depend of the pollutants in the weld metal

Operating data



Polarity:	Shielding gas:	ø (mm)
DC (–)	100 % Argon	1.6 2.0 2.4 3.0