

ER Ti 2

Titanium wire and TIG-rods

Specifications:

DIN 1737: ~SG Ti 2
Werkstoff-Nr. ~3.7036
AWS-Classification: ER Ti 2

Application:

Welding of pure Titanium and Titanium alloys with mid. strength and good elongation

Chemical Composition Element by weight (%):

C: $\leq 0,08$ N: $< 0,05$ Fe: $< 0,025$ O₂: $< 0,18$ H: $< 0,013$ Ti: Rest

Mechanical Properties:

(typical)

Tensile Strength (Rm)	395-540 N/mm ²
0,2%Elongation	275 N/mm ²
Elongation (A)(Lo=5do)	20 %
Hardness:	180 HB

Shielding Atmosphere: TIG-rods

pure argon

Gasconsum:

flash :	12-14 l/min
shielding ::	1 – 2 l/min

Operating Parameter

rods size 1,5mm : 35-60 Ampère
rods size 2,0mm : 70-80 Ampère