



MIG T40

Classification

AWS A5.16 : ERTi-2
AMS : 4951

ISO 24034 : S Ti 0120 (Ti99.6)

Description & Applications

Solid wire for GMAW of pure titanium Grade 2 type.

Main applications: Heat exchangers, condensers, evaporators for nuclear plants, oil refinery, aeronautical and chemical industries.

Typical Chemical Composition (%)

	C	N	H	O	Fe	Y	O/T	Ti
Min				0.08				
Max	0.03	0.015	0.005	0.16	0.12	0.005	0.20	Rem.
Type	0.01	0.004	0.001	0.085	0.02	0.001	<0.20	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	290	390-540	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: I1 (100% Ar) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	

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