MIG TA6V4 ELI

Classification

AWS A5.16 : ERTi-23
AMS : 4956

ISO 24034 : S Ti 6408 (TiAl6V4A)

Description & Applications

Solid wire for GMAW of similar titanium alloys. The decreaseon of interstitial elements increase the weldability and the hardness compared to TA6V4.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	N	H	O	Fe	Al	V	Y	O/T	Ti
Min				0.03		5.50	3.50			
Max	0.03	0.012	0.005	0.11	0.15	6.5	4.50	0.005	0.10	Rem.
Type	0.01	0.005	0.001	0.06	0.06	6.2	4.0	0.001	<0.10	Rem.

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	900	960-1270	8

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 180 - 350	18 - 26 18 - 28 22 - 32 22 - 32	ISO 14175: I1 (100% Ar) 15-20 l/min