



MIG TA6V4

Classification

AWS A5.16 : ERTi-5
AMS : 4954

ISO 24034 : S Ti 6402 (TiAl6V4B)

Description & Applications

Solid wire for GMAW of similar titanium alloys.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	N	H	O	Fe	Al	V	Y	O/T	Ti
Min				0.12		5.50	3.50			
Max	0.05	0.030	0.015	0.18	0.22	6.75	4.50	0.005	0.20	Rem.
Type	0.02	0.006	0.004	0.15	0.18	6.2	4.0	0.001	<0.20	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	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	
	1.6	180 - 350	22 - 32	

FT En-MT24-170803

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