MIG TI6.2.4.2

Classification

AMS : 4952

Description & Applications

Solid wire for GMAW of similar titanium alloys. Excellent oxydation resistance at high temperature.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Mo	Zr	Sn	Al	Fe	O
Min			1.80	3.60	1.80	5.50		
Max	0.04	0.10	2.20	4.40	2.20	6.50	0.10	0.15
Type	0.02	0.08	2.0	4.0	2.0	6.0	0.05	0.12

	N	H	Y	B	E/O	O/T	Ti
Min							
Max	0.0400	0.0125	0.0050	0.0030	0.10	0.40	Rem.
Type	0.01	0.001	0.001	0.001	<0.10	<0.40	Rem.

All Weld Metal Mechanical Properties

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

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