



## 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 <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	-	-	-

### 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-MT32-171122

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