

## ER Ti 5

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid Titanium based welding wire (Grade 5) with extreme high strenght.

**APPLICATIONS** Aerospace, marine, chemical plants, process plants, power generation, oil and gas extraction, medical and sports.

**PROPERTIES** Excelent weldability, and can be heat treated to a higher strength or toughness. Grade 5 is used in aircraft components such as landing gear, wing spars, and compressor blades. Its corrosion resistance is generally comparable to Grade 2 and it is often used in corrosion service where higher strength is required, particularly in shafts, high strength bolting, and keys.  
The weld deposit is ductile and offers excellent corrosion resistance in oxidizing environments. The unique combination of mechanical strenght and corrosion resistance makes the alloy a prefered choice in many applications to prehend or solve problems. The wire is cleaned in a very special way to obtain porosity free and a ductile weld deposit.

**CLASSIFICATION**

AWS	A 5.16: ER Ti 5
EN ISO	24034: STi-6402c
DIN: W.Nr.	3.7165
DIN	1737:

**SUITABLE FOR** Titanium grade 5, UNS R56400, AMS 4954

**WELDING POSITIONS:**



**FILLER METAL ANALYSIS %**

C	O	N	H	Fe	Al	V
<0.05	0.12-0.20	<0.03	<0.015	<0.22	5.5-6.7	3.5-4.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
	>890	>810					

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / tube	kg / 6pack	kg / 1000
1.6	1000		5		
2.4	1000		5		
3.2	1000		5		

**REDRYING TEMPERATURE** not required

**NOTE** Also available as spooled wire :0.8 mm, 1.0 mm and 1.2 mm (D-100 / D-200 / D-300)