



# CEWELD ERTi-5 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                             |                         |                      |                    |          |      |
|---------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-------------------------|----------------------|--------------------|----------|------|
| TYPE                                              | Titanium Tig welding wire grade 5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                             |                         |                      |                    |          |      |
| APPLICATIONS                                      | Aerospace, marine, chemical plants, process plants, power generation, oil and gas extraction, medical and sports.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                             |                         |                      |                    |          |      |
| PROPERTIES                                        | Excellent 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 strength and corrosion resistance makes the alloy a preferred choice in many applications to prevent 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: ERTi-5              |                         |                      |                    |          |      |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 24034: S Ti 6402 / TiAl6V4B |                         |                      |                    |          |      |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 3.7165                      |                         |                      |                    |          |      |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 51                          |                         |                      |                    |          |      |
| SUITABLE FOR                                      | 3.7164, 3.7165<br>Titanium grade 5,<br>UNS R56400, AMS 4954, TiGr5, Ti6Al4V, AMS4911                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                             |                         |                      |                    |          |      |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                             |                         |                      |                    |          |      |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                               |                             |                         |                      |                    |          |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | V                           | H                       | N                    | O                  | Al       | Ti   |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 4                           | 0.01                    | 0.01                 | 0.18               | 6.2      | Rem. |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                             | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |      |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                             | 810                     | 890                  |                    | HRc      |      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                             |                         |                      |                    |          |      |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                             |                         |                      |                    |          |      |



## CEWELD ERTi-5 Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| ERTI-5 TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 2,5     | 8720663406545 |
| ERTI-5 TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 2,5     | 8720663406552 |
| ERTI-5 TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 2.5     | 8720663406569 |
| ERTI-5 TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 2,5     | 8720663406576 |
| ERTI-5 TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 2,5     | 8720663406583 |