

## ERTi-7

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid drawn Titanium Grade 7 welding wire.

**APPLICATIONS** Grade 7 has the same mechanical properties as Grade 2. The 0.12 wt% palladium addition improves corrosion performance under mildly reducing conditions or where crevice or under-deposit corrosion is a problem. ERTi-7 can be considered for welding Grade 2 or 16 where improved corrosion performance is desired.

**PROPERTIES** 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: ER Ti 7
	UNS: R52401
EN ISO	24034:STi-2401
DIN: W.Nr.	3.7235
DIN	1737:

**SUITABLE FOR** Titanium grade 7, Grade 2, Grade 16

**APPROVALS** CE approved

**WELDING POSITIONS:**



### ALL WELD METAL WEIGHT %

C	O	N	H	Fe	Al	V	Pd
<0.03	0.08-0.16	<0.015	<0.008	<0.12	-	-	0.12-0.25

### 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	
as welded	275	400	20				

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Current (A)	Packing kg / tube
	Length (mm)			
1.6	1000			5
2.0	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)