

GETIG TI-1

TIG WELDING FILLER WIRE

IDENTIFICATION

Getig Ti-1, ERTi-1

CLASSIFICATION

AWS/SFA 5.16: ER Ti -1

DESCRIPTION

Getig Ti -1 is specially made TIG wire for welding of unalloyed grade of Titanium metal. The wire is used for fabrication of process equipments like pressure vessel, column, tanks, heat-exchanger etc. Care should be taken during welding specially cooling of the weld metal under protection of ultra-high pure grade of shielding gas such as argon.

CHEMICAL ANALYSIS (RANGE) %

| C | O | N | H | Fe | Ti |
|-------------|-----------|-----------|-----------|----------|------|
| 0.03 max | 0.03-0.10 | 0.012 max | 0.005 max | 0.08 max | Rem. |

TYPICAL APPLICATIONS

- Used where highest ductility is required, explosive cladding, loose linings, expanded metal and deep drawing application.
- Used in electrolytic application like coated anodes, substrates for production of chlorine and sodium chlorates.

SPECIAL RECOMMENDATION

- The Titanium metal should be free of thick oxide, water, grease, dirt etc. therefore chemical cleaning is required prior to welding.
- The filler metal (wire) should be chemically cleaned and should be free of oxides, dirt, moisture etc.
- The weld metal need to be shielded from the ambient air atmosphere by auxiliary inert gas shielding until it has cooled below 400°C.

SHIELDING GAS : Ultra high pure grade of Argon, 99.999% Pure.

PACKING PARAMETERS

| Size (mm) | Length (mm) | Packing / Pkt (kg) | Packing / Box (kg) |
|-------------|-------------|--------------------|--------------------|
| 1.6 | 1000 | 2 | 2 x 4 = 8 |
| 2 | 1000 | 2 | 2 x 4 = 8 |
| 2.40 / 2.50 | 1000 | 2 | 2 x 4 = 8 |
| 3.15 / 3.20 | 1000 | 2 | 2 x 4 = 8 |