

Soudotec **T792**

DC-

TITANIUM**DESCRIPTION**

Titanium alloy TIG rod for welding titanium and its alloys. Particularly recommended for grades 1, 2, 3, 4 or similar grades.

CHARACTERISTICS

- High mechanical resistance
- Low bonding temperature
- Good color match with titanium
- Easy to use
- Conform to standard AWS 5.16 standard: ERTi-2

TYPICAL APPLICATIONS

Recommended for motorcycle muffler and exhaust pipes and high performance vehicles, condenser pipes, chemical industries, paper industries and other corrosive applications.

PROCEDURE

Clean the welding area of all traces of grease and impurities. When welding use a blanket of argon or a trail of argon. Always maintain the hot end of the TIG rod on the inside of the inert gas protection produced by the TIG torch during the entire welding procedure. During all operations the weld or the bead should be under an atmosphere of argon even when cooling the part until you reach a temperature of 500°F (260°C) to avoid oxidation. Always remove the contaminated end of the rod between each pass. At the end of welding, check if the bead color is bright and silver.

MECHANICAL PROPERTIES

Tensile strength: 50 000 psi (345 MPa)
Yield strength : 40 000 psi (275 MPa)

WELDING PARAMETERS

Diameter: 1.6 mm (1/16")
Polarity: DC –
Gas: Pure argon
Gas flow: Approx. 35 – 40 C.F.H.

Rév.: 7_01

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