



Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard AWS A5.16	Chemical Composition %									
	C	O	N	H	Fe	Al	V	Ti	Other Each	Other Total
ERTi- 1	≤0.03	0.03~0.10	≤0.012	≤0.008	≤0.08	--	--	Rest	≤ 0.05	≤0.15
ERTi- 2	≤0.03	0.08~0.16	≤0.015	≤0.008	≤0.12	--	--	Rest	≤ 0.15	≤0.15
ERTi- 5	≤0.05	0.12~0.20	≤0.03	≤0.015	≤0.22	5.5~6.7	3.5~4.5	Rest	≤ 0.15	≤0.15
Type	Spool (MIG)					Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0					1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/0.5kg S270,S300/6kg-7kg					S200/2kg S360/20kg 5kg/box 10kg/box length :1000MM				
Mechanical Properties	Fusion Temperature ℃		Electrical IACS	Density g/mm3		Tensile Mpa	Yield Mpa		Elongation %	
ERTi- 1	---		---	---		≥240	140~200		≥24	
ERTi- 2	---		---	---		≥345	275~340		≥20	
ERTi- 5	---		---	---		≥860	780~830		≥10	
	Diameter (MM)		1.2		1.6			2.0		
MIG Welding	Welding Current - A		180 – 300		200 – 400			240 – 450		
	Welding Voltage- V		18 – 28		20 – 24			22 – 34		
TIG Welding	Diameter (MM)		1.6 – 2.4		2.4 – 4.0			4.0 – 5.0		
	Welding Current - A		150 – 250		200 – 320			220 – 400		
Performance characteristics	AWS A5.16 ERTi- 1 and ERTi- 2 are commercially pure titanium solid wires with excellent corrosion resistance. ERTi- 1 is softer and more ductile than ERTi- 2, used for welding Grade1 pure titanium. ERTi- 2 is the most common pure titanium filler for Grade1/2/3/4 CP titanium. ERTi- 5 is Ti- 6Al- 4V alloy filler metal, delivering high strength weld metal for welding Ti- 6Al- 4V titanium alloy widely used in aerospace. All require high purity argon shielding gas for GTAW / GMAW welding.									



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