

# CARBO S-Ti 2

# CARBO T-Ti 2

## International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	~ 3.7036	
DIN 1737	SG Ti 2	WSG Ti 2
AWS SFA-5.16	ER Ti 2	ER Ti 2

## Approvals

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## Application notes

Titanium MIG/TIG wire for welding of pure Titanium and Titanium alloys with good elongation and medium strength.

## Mechanical properties of all-weld-metal

(typical values)

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yielding strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Hardness HB
400-540	275	20	180

## Weld metal analysis

(typical, wt %)

C	Fe	N	H	O <sub>2</sub>	Ti
< 0,08	< 0,025	< 0,05	< 0,013	< 0,18	balance

## Gas types EN 439

S = massive wire

T = bare rod

pure

## Gasconsum

flash  
shielding

12-14 l / min  
1-2 l / min

## Current

= +

= -

Diameter mm

1,5 2,0 2,4 3,2 4,0

Welding amps (A) min.

35 70

(A) max.

60 80

## coils, weight

Rev. 000