



# ERTi-7 (ERTi-0.2Pd) Welding Wire and Rod

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)

Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925



## ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy ERTi-7 Titanium has matching properties to ASTM base metal Grade 7 titanium and also the same properties as Grade 2 titanium but with better corrosion performance. Alloyed with 0.12% palladium this filler yields an improved performance where crevice or under-deposit corrosion may be found. ERTi-7 may be found in some case for welding titanium base metal grades of 2, 16, and 26.

## TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	100-185	9-12	1/2"	20	1/16-1/8"
3/32"	3/32"	150-250	11-15	5/8"	25	1/8- 3/16"
1/8"	1/8"	200-375	11-15	3-4"	30	1/4-1/2"

## TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Ar & Ar+He (cfh)
0.030	450-650	100-195	16-20	35-65
0.035	480-420	165-285	18-27	35-65
0.045	500-880	250-360	31-35	35-65

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## WIRE CHEMISTRY (%) & TYPICAL WELD METAL PROPERTIES

Carbon	0.03 max	Tensile Strength (psi)	50,000
Oxygen	0.08-0.16	Yield Strength (psi)	40,000
Nitrogen	0.015 max	Elongation	20 %
Hydrogen	0.008 max		
Iron	0.12 max		
Palladium	0.12-0.25		

**AVAILABLE SIZES:** TU ERTI-7 = Cut lengths of 040, 1/16, 3/32, 1/8

Other sizes available – please inquire

**SPECIFICATIONS;** ANSI/AWS A5.16 ERTi-7  
ASME SFA A5.16 ERTi-7

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