



WASHINGTON ALLOY'S Quality Management System is Certified to **ISO 9001:2008** Cert # 05-R0925

ERTi-9 (Ti 3Al-2.5V) Welding Wire and Rod

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy ERTi-9 Titanium has matching properties to ASTM base metal Grade 9 titanium and also known as the half version of Grade 5 titanium. Used for applications where better ductility, formability and weldability are needed but a lower tensile are acceptable. Often used in oil production, aircraft honeycomb foil, piping and pressure vessels frames and hydraulic system tubing, as well as sports equipment, including tennis rackets, bicycles and golf clubs...

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)	90,000
Oxygen	0.06-0.12	Yield Strength (psi)	70,000
Nitrogen	0.012 max	Elongation	14 %
Hydrogen	0.005 max		
Iron	0.20 max		
Aluminum	2.5-3.5		
Vanadium	2.0-3.0		

AVAILABLE SIZES: TU ERTi-9 = Cut lengths of 035, 1/16,

Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.16 ERTi-9
ASME SFA A5.16 ERTi-9



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