



Titanium Welding Wire and Rod

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

Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925



Basic Guidelines & settings

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

Welding any grade of Titanium will require very controlled welding guidelines. You will need to ensure the base as well as the filler is **EXTREMELY** clean and weldment has total gas coverage during welding & until the temperature reaches 600° F or lower after welding.

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