

# TITAN

## A HIGH QUALITY TIG WIRE FOR WELDING COMMERCIALY PURE TITANIUM

### DC STRAIGHT POLARITY

### GENERAL CHARACTERISTICS:

A premium TIG wire formulated for the repair of commercially pure Titanium parts.

### APPLICATIONS:

For commercially pure Titanium parts **only**. To eliminate contamination, do not touch wire with bare hands.

### TECHNICAL DATA:

Shielding Gas ..... 100% Argon or 75/25 Argon Helium  
Current ..... DC Straight Polarity (Electrode -)

### PROCEDURE:

All surface contamination must be removed from weld area by chemical means. Preheat and interpass temperature must not exceed 250°F (121°C). Use DC straight polarity. Flat position welding is recommended. Use 100% AR or 75/25 shielding gas. Allow part to air cool.

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TITANIUM REPAIR TITAN