

## NOUVE T-Ti-1

**ASME SFA-5.16/SFA-5.16M ERTi-1**

**UNS No:Ti 0100**

### DESCRIPTIONS:

- NOUVE T-Ti-1 is the purest grade and is suitable for welding titanium grade 1,2,3 and 4. With the restriction that mechanical properties are much less than grade 2,3 and 4. The weld deposit is ductile and offers excellent corrosion resistance in oxidizing environments. This alloy finds applications in Chemical industry and offers excellent weldability.

### APPLICATIONS:

- Typical applications include for process equipment like pressure vessels, columns, tanks, heat exchangers, shafts, blowers, fans, condenser tubing, valves, fittings and pipe.

### CHEMICAL COMPOSITION OF FILLER METAL (wt%) :

| ELEMENTS      | AWS SPEC    | TYPICAL |
|---------------|-------------|---------|
| Carbon (C)    | 0.03 max    | 0.02    |
| Hydrogen (H)  | 0.005 max   | 0.003   |
| Iron (Fe)     | 0.08 max    | 0.02    |
| Nitrogen (N)  | 0.012 max   | 0.01    |
| Oxygen (O)    | 0.03 – 0.10 | 0.04    |
| Titanium (Ti) | -           | Balance |

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### RECOMMENDED WELDING TECHNIQUES:

**Current/Polarity** : DCEN  
**Shielding Gas** : 100% Ar

| SIZE (mm)  | AMPERAGE (A) | VOLTAGE (V) | GAS FLOW RATE (lpm) |
|------------|--------------|-------------|---------------------|
| 1.6 x1000  | 80-110       | 13-16       | 10-15               |
| 2.0 x1000  | 90-130       | 14-18       | 10-15               |
| 2.4 x1000  | 120-175      | 15-20       | 10-15               |
| 3.15 x1000 | 150-220      | 15-20       | 10-15               |

### PACKING:

| SIZE (mm)  | PACKING MODE        | WEIGHT (kgs.) |
|------------|---------------------|---------------|
| 1.6x1000   | TUBULAR PLASTIC BOX | 5.0           |
| 2.0 x1000  | TUBULAR PLASTIC BOX | 5.0           |
| 2.4 x1000  | TUBULAR PLASTIC BOX | 5.0           |
| 3.15 x1000 | TUBULAR PLASTIC BOX | 5.0           |