

**TITANIUM ALLOY WELDING WIRE
6Al-2Sn-4Zr-2Mo**

UNS R54620

1. SCOPE:

1.1 Form: This specification covers a titanium alloy in the form of welding wire.

1.2 Application: Primarily for use as filler metal for gas-metal-arc and gas-tungsten-arc welding.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications and Aerospace Recommended Practices shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2249 - Chemical Check Analysis Limits, Titanium and Titanium Alloys
AMS 2350 - Standards and Test Methods
AMS 2813 - Packaging of Welding Wire, Standard Method
AMS 2815 - Identification, Welding Wire, Line Code System
AMS 2816 - Identification, Welding Wire, Color Code System

2.1.2 Aerospace Recommended Practices:

ARP 1876 - Weldability Test for Weld Filler Metal Wire

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM E120 - Chemical Analysis of Titanium and Titanium Alloys

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3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E120, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Aluminum	5.50	- 6.50
Zirconium	3.60	- 4.40
Tin	1.80	- 2.20
Molybdenum	1.80	- 2.20
Silicon	--	0.10
Iron	--	0.10
Carbon	--	0.04
Copper (3.1.1)	--	0.10
Oxygen	--	0.15
Nitrogen	--	0.0400 (400 ppm)
Hydrogen	--	0.0125 (125 ppm)
Boron (3.1.1)	--	0.0030 (30 ppm)
Yttrium (3.1.1)	--	0.0050 (50 ppm)
Residual Elements, each (3.1.1)	--	0.10
Residual Elements, total (3.1.1)	--	0.40
Titanium	remainder	

- 3.1.1 Determination not required for routine acceptance.

- 3.1.2 Check Analysis: Composition variations shall meet the requirements of AMS 2249.

- 3.2 Condition: Cold drawn, bright finish, in a temper which will provide proper feeding of the wire in machine welding equipment.

- 3.2.1 Wire shall be furnished on disposable spools for machine welding or in cut lengths for manual welding, as ordered.

- 3.2.2 In-process annealing between cold rolling or drawing operations shall be performed in a suitable protective atmosphere.

- 3.2.3 Oxides, dirt, oil, and drawing compounds shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

- 3.3 Properties: Wire shall conform to the following requirements:

- 3.3.1 Weldability: Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds, determined by a procedure agreed upon by purchaser and vendor. In case of dispute where no procedure has been previously agreed to, ARP 1876 shall apply.

3.3.2 Spooled Wire: Shall conform to 3.3.2.1 and 3.3.2.2.

3.3.2.1 Cast: Wire wound on standard 12-inches (305-mm) diameter spools shall have imparted to it a curvature such that a specimen sufficient in length, 4 - 8 feet (1219 - 2438 mm), to form one loop, when cut from the spool and laid on a flat surface shall form a circle 15 - 30 inches (382 - 762 mm) in diameter.

3.3.2.2 Helix: The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.4 Quality:

3.4.1 Alloy shall be multiple melted; at least one of the melting cycles shall be under vacuum. The first melt shall be made by consumable electrode, nonconsumable electrode, electron beam, or plasma arc melting practice. The subsequent melt or melts shall be made using consumable electrode practice with no alloy additions permitted in the last consumable electrode melt.

3.4.1.1 The atmosphere for nonconsumable electrode melting shall be vacuum or shall be inert gas at a pressure not higher than 250 mm of mercury.

3.4.1.2 The electrode tip for nonconsumable electrode melting shall be water-cooled copper.

3.4.2 Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.5 Sizes and Tolerances: Wire shall be supplied in the sizes and to the tolerances shown in 3.5.1 and 3.5.2.

3.5.1 Diameter:

TABLE I

Form	Nominal Diameter Inch	Tolerance, Inch	
		Plus	Minus
Cut Lengths	0.030, 0.045, 0.062, 0.078	0.002	0.002
Cut Lengths	0.094, 0.125, 0.156, 0.188	0.003	0.003
Spools	0.007, 0.010, 0.015, 0.020	0.0005	0.0005
Spools	0.030, 0.035, 0.045	0.001	0.002
Spools	0.062, 0.078, 0.094	0.002	0.002

TABLE I (SI)

Form	Nominal Diameter Millimetres	Tolerance, Millimetre	
		Plus	Minus
Cut Lengths	0.76, 1.14, 1.57, 1.98	0.05	0.05
Cut Lengths	2.39, 3.18, 3.96, 4.78	0.08	0.08
Spools	0.18, 0.25, 0.38, 0.51	0.013	0.013
Spools	0.76, 0.89, 1.14	0.03	0.05
Spools	1.57, 1.98, 2.39	0.05	0.05

3.5.2 Length: Cut lengths shall be furnished in 18, 27, or 36 inch (457, 686, or 914 mm) lengths, as ordered, and shall not vary more than +0, -1/2 inch (-13 mm) from the length ordered.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of wire shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.4. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the wire conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1) and tolerances (3.5) are classified as acceptance tests and shall be performed on each heat or lot as applicable.

4.2.2 Periodic Tests: Tests to determine conformance to requirements for weldability (3.3.1), cast (3.3.2.1), and helix (3.3.2.2) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.