


**AWS G2.4/G2.4M:2007**  
**An American National Standard**



# **Guide for the Fusion Welding of Titanium and Titanium Alloys**



**American Welding Society**



**AWS G2.4/G2.4M:2007**  
**An American National Standard**

**Approved by the**  
**American National Standards Institute**  
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# **Guide for the Fusion Welding of Titanium and Titanium Alloys**

**1st Edition**

Prepared by the  
American Welding Society (AWS) G2 Committee on Joining Metals and Alloys

Under the Direction of the  
AWS Technical Activities Committee

Approved by the  
AWS Board of Directors

## **Abstract**

The standard *Guide for the Fusion Welding of Titanium and Titanium Alloys* provides instructional guidance for the welding of titanium and titanium alloys. This guide explains processes, equipment, materials, workshop practices, joint preparation, welding technique, tests, and the repair of defects.



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# Table of Contents

	<b>Page No.</b>
<i>Personnel</i> .....	v
<i>Foreword</i> .....	vii
<i>List of Tables</i> .....	xi
<i>List of Figures</i> .....	xi
<b>1. Scope</b> .....	<b>1</b>
<b>2. Normative References</b> .....	<b>1</b>
<b>3. Terms and Definitions</b> .....	<b>1</b>
<b>4. Introduction</b> .....	<b>2</b>
4.1 Oxygen, Nitrogen, Carbon, Iron, and Titanium.....	3
4.2 Surface Oxide Film.....	3
<b>5. Arc Welding Processes</b> .....	<b>3</b>
5.1 Gas Tungsten Arc Welding (GTAW).....	4
5.2 Gas Metal Arc Welding (GMAW).....	4
5.3 Plasma Arc Welding (PAW).....	4
<b>6. Equipment</b> .....	<b>4</b>
6.1 Power Source.....	4
6.2 Welding Torch.....	4
6.3 Tungsten Electrodes.....	5
<b>7. Materials</b> .....	<b>6</b>
7.1 Base Metals.....	6
7.2 Filler Metals.....	6
7.3 Procedure Qualification.....	8
<b>8. Workshop Practice</b> .....	<b>8</b>
8.1 Workshop Layout.....	8
8.2 Material Identification and Storage.....	8
8.3 Inert Gas Protection.....	8
8.4 Inert Gas Distribution.....	9
8.5 In-Chamber Welding.....	9
8.6 Open-Air Welding.....	10
8.7 Shielding Gases.....	12
8.8 Argon Safety.....	12
<b>9. Joint Preparation</b> .....	<b>13</b>
9.1 Joint Design.....	13
9.2 Cutting.....	13
9.3 Preliminary Preparation.....	13
9.4 Cleaning for Welding.....	15
9.5 Fitup and Tack Welding.....	16
<b>10. Welding Technique</b> .....	<b>16</b>
10.1 Welding Parameters.....	16
10.2 Preheating.....	16

	<b>Page No.</b>
10.3 Filler Metal Practice .....	16
10.4 Starting and Stopping the Arc.....	17
10.5 Electrode Practice .....	17
10.6 Wire Feeding .....	17
10.7 Interpass Cleaning .....	17
10.8 Interpass Temperatures.....	17
<b>11. In-Process Weld Quality Tests .....</b>	<b>17</b>
11.1 Visual Inspection .....	17
11.2 Dew Point Testing .....	19
11.3 Bend Testing.....	19
11.4 Hardness Testing .....	19
<b>12. Nondestructive Test.....</b>	<b>20</b>
12.1 Radiography.....	20
12.2 Liquid Penetrant Testing.....	20
12.3 Ultrasonic Inspection.....	20
<b>13. Repair of Defects .....</b>	<b>20</b>
13.1 Fabrication Defects.....	20
13.2 Repairs Following Service Failures.....	21
13.3 Porosity.....	21
13.4 Filler Metals for Welding Titanium Alloys Metal Joints .....	21
Annex A (Informative)—Requirements of Base Metals .....	23
Annex B (Informative)—Requirements of Filler Metals .....	27
Annex C (Informative)—Bibliography .....	31
Annex D (Informative)—Classifications for Titanium and Titanium Alloys .....	33
Annex E (Informative)—Guidelines for the Preparation of Technical Inquiries.....	37
List of AWS Documents on Joining Metals and Alloys .....	39

## List of Tables

<b>Table</b>	<b>Page No.</b>
1 Tungsten Electrode Amperage Guidelines .....	6
2 ASTM Specifications for Product Forms .....	6
3 Recommended Filler Metals.....	7
4 Recommended Shielding Gas Purity and Dew Point .....	9
5 Typical Joint Designs .....	14
6 Typical Parameters for GTAW, GMAW, and PAW .....	16
7 Surface Color in Titanium Welds .....	18
8 Bend Test Requirements for Titanium Alloys.....	19
A.1 Chemical Composition Requirements of Base Metals (from ASTM B 265).....	24
A.2 Tensile Strength Requirements of Base Metals.....	25
B.1 Chemical Composition Requirements of Filler Metals—Weight-Percent .....	27
B.2 Chemical Composition Requirements for Titanium and Titanium Alloy Electrodes and Rods .....	29
D.1 Guidelines for Compatible Filler Materials.....	33
D.2 Base Material Grouping S-51 .....	34
D.3 Base Material Grouping S-52 .....	34
D.4 Base Material Grouping S-53 .....	35
D.5 Base Material Grouping S-54 .....	36
D.6 Filler Material Grouping A-51B.....	36
D.7 Filler Material Grouping A-52B.....	36
D.8 Filler Material Grouping A-53B.....	36

## List of Figures

<b>Figure</b>	<b>Page No.</b>
1 Titanium Surface Oxide Formed by Heating in Air .....	3
2 Large-Diameter Gas Cup and Lens for Titanium Welding .....	5
3 Tungsten Electrode Tip Shape.....	5
4 Collapsible Plastic Chamber Purged with Argon .....	10
5 Typical Trailing Shield Design.....	11
6 Examples of Backup Shields for Manual GTAW .....	12
7 Color Sequence in Titanium .....	18
8 Contamination of Tungsten Electrode from Air Entrainment .....	19

# Guide for the Fusion Welding of Titanium and Titanium Alloys

## 1. Scope

This guide provides information on welding processes and procedures that are recommended for use in titanium fabrication. The document presents detailed and up-to-date technical information on the best practices to allow first-time users of titanium as well as established fabricators to join titanium parts into high quality components.

This standard makes use of both the U.S. Customary Units and the International System of Units (SI). The latter are shown within brackets [ ] or in appropriate columns in tables and figures. The measurements may not be exact equivalents; therefore, each system must be used independently of the other without combining in any way. The standard with the designation G2.4:2007 uses U.S. Customary Units. The standard with the designation G2.4M:2007 uses SI Units.

Safety and health issues and concerns are beyond the scope of this standard and therefore are not fully addressed herein. Safety and health information is available from other sources, including, but not limited to, ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*, and applicable federal and state regulations.

## 2. Normative References

The following standards contain provisions which, through reference in this text, constitute mandatory provisions of this AWS standard. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments to, or revision of, any of these publications do not apply. (See Annexes C and D for complete lists of standards and specifications for titanium fabrication.)

AWS Documents:<sup>1</sup>

1. AWS A3.0, *Standard Welding Terms and Definitions*;
2. AWS A5.12/A5.12M, *Specification for Tungsten and Tungsten Alloy Electrodes for Arc Welding and Cutting*;

<sup>1</sup>AWS standards are published by the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

3. AWS A5.16/A5.16M:2004, *Specification for Titanium and Titanium Alloy Welding Electrodes and Rods*;

4. AWS A5.32/A5.32M, *Specification for Welding Shielding Gases*; and

Other Documents:

5. ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*.<sup>2</sup>

## 3. Terms and Definitions

For the purposes of this document, the following terms and definitions apply:

**alpha grades or alloys.** The alpha ( $\alpha$ ) grades or alloys are generally weldable and nonheat treatable. They are materials with relatively large amounts of alpha stabilizers and low concentrations of beta ( $\beta$ ) stabilizers. They are sometimes referred to as having predominately an alpha phase. They have medium strength, good notch toughness, and good resistance to creep at elevated temperatures. Silicon is sometimes added to enhance creep strength. A common alpha alloy is commercially pure (CP) titanium.

**allotrope.** An allotrope is a structurally different form of an element such as graphite and diamond which are allotropes of carbon. As can be seen with the example of carbon allotropes, certain physical properties can vary dramatically from allotrope to allotrope. Alpha and beta allotropes of titanium have very different properties. Alpha and beta allotropes are also referred to as phases.

**alpha phase.** The low-temperature allotrope of titanium with a hexagonal close-packed (HCP) crystal structure. The alpha phase promotes increased weldability and higher creep strength. Interestingly, the interstitial alloying elements of the alpha stabilizing type are

<sup>2</sup>ANSI Z49.1 is published by the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.