

# MIG & TIG

## Oxford Alloy<sup>®</sup> Zr2

AWS ERZr2 • Zirconium

### Key Features

- ❖ Excellent corrosion resistance to many chemical solutions.
- ❖ Typical applications include heat exchangers, stripper columns, reactor vessels, pumps, valves, and corrosive media piping.
- ❖ Can be machined, welded and fabricated using the same equipment and processes used in fabrication of stainless steel, nickel-based alloys and titanium.

### Conformances

AWS/ASME SFA 5.24

ERZr2

UNS R60702

### Chemical Composition - As required per AWS 5.24

Zr+Hf	Hf	Fe+Cr	H	N	C	O
99.0 min	4.5 max	0.20 max	0.005 max	0.015 max	0.03 max	0.11- 0.15

### Mechanical Properties - As required by AWS 5.24

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
AWS Requirements	Not Specified		
Typical Results - As welded	380 (55)	210 (30)	16



### Typical Welding Parameters

Diameter		Process	Volt	Amps	Shielding Gas
in	(mm)				
1/16	1.6	GTAW	12-15	80-150	100% Argon
3/32	2.4	GTAW	12-15	130-200	100% Argon
1/8	3.2	GTAW	112-15	180-225	100% Argon

### Diameters & Packaging

Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
1/16	GTAW	5 lb tube   20 lb carton	1.6	GTAW	2 kg tube   8 kg carton
3/32	GTAW	5 lb tube   20 lb carton	2.4	GTAW	2 kg tube   8 kg carton
1/8	GTAW	5 lb tube   20 lb carton	3.2	GTAW	2 kg tube   8 kg carton

Actual test results may vary. Refer test result disclaimer on page 160.