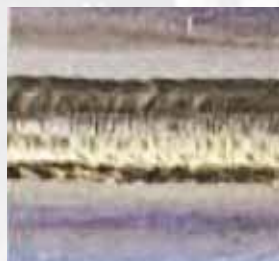


Heat Tint Recognition Chart For Titanium Welding

Oxidation colours have many different variations.
We have assembled a few here as guidelines.



1



2



3



6



7

Legend:

1, 1a, 1b

Excellent gas coverage. Clean, silver looking welds 10 ppm O₂ level.

2, 2a

Weld slightly straw coloured shows higher oxygen level due to poor trailing shield gas coverage causing slight oxidation.

3, 3a, 3b

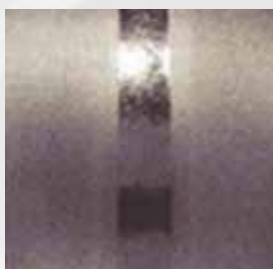
Weld and heat affected zone are now deeper straw and blue, showing higher oxygen level caused by faster speed losing trailing shield gas.

4, 4a, 5, 5a

Weld blue and dark straw showing heavier oxide layer caused by excessively high oxygen level.

6, 6a, 7, 7a, 7b

Welds silvery to white with intolerable oxidation level.



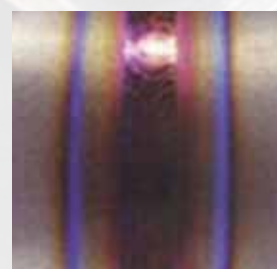
1a



2a



3a



4



5



1b



2b



3b



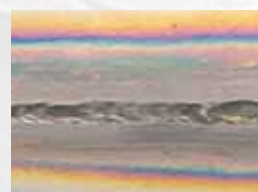
4a



5a



6a



7a



7b

Oxidation colours need to be eliminated prior to additional welding.
Use a Weld Purge Monitor[®] to eliminate oxygen to prevent oxides from forming and save this additional work load.

Use Argweld[®] PurgEye[®] Weld Purge Monitors[®] to detect oxygen levels down to 10 ppm to eliminate oxidation, weld reject and potential weld failure.

The hotter a Titanium weld becomes, the easier it is to oxidise, so the best solution is to keep the purge level as close to 10 ppm oxygen as possible.



Huntingdon Fusion Techniques HFT[®] with over 40 years of high integrity, totally ethical business practices.

The only innovators and developers of Weld Purging Products.
The owners of the Weld Purge Monitor[®] Registered Trade Mark.

For more information, please contact hft@huntingdonfusion.com

Tint Chart 06-07-2015 ME