



Inomaxx[®] 2

Maximum performance for welding stainless steel

The Inomaxx[®] gases have been developed to give optimum weld quality and ease of use without compromise on material performance. Inomaxx[®] gases also provide a high-grade surface finish with low reject rates and superb environmental performance.

The reliable gas for stainless steel of thin and medium thicknesses

Inomaxx[®] 2 is a mixture of argon and CO₂ used to weld stainless steel:

- Excellent weld quality with low spatter levels and a smooth and regular finish.
- Highly suited to pulsed arc transfer.
- Particularly suitable for welding thin and medium thicknesses and suitable for all modes of metal transfer.



Approved welding procedure Inomaxx[®] 2

Manufacturer:	Air Products PLC Air Products Ireland Ltd
Welding process:	MAG 135
Root welding process:	n/a
Joint type:	Fillet

Joint design

Preparation of parts	Sandblasting and solvent cleaning
Parent material and specifications	Stainless steel EN 10088-2 X2CrNi 19-11
Composition	C - 0.030% max. Si - 1.0% max. Mn - 2.0% max. P - 0.049% max. S - 0.030% max. Cr - 17.0 / 19.0% Ni - 9.0 / 12.5%
Material thickness	6 mm
Outside diameter	n/a
Welding position	Flat (PB)

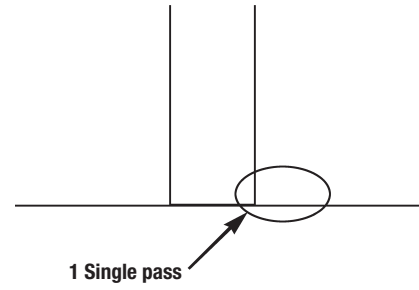
Welding details

Run	Process	Diameter of filler metal (mm)	Current (A)	Voltage (V)	Type of Current & Polarity	Wire feed Speed (m/min)	Travel Speed (mm/min)	Heat Input (KJ)
1	MAG	1.0	240	27	DC+	13.5	335	1.16
2								
3								
4								
5								
6								
Filler metal and specification		AWS A5.9 ER316LSi						
Filler metal composition		C - 0.03% max. - Si - 0.65 / 1.00% Mn - 1.50 / 2.50% - P - 0.030% max. S - 0.030% max. - Cr - 19.5 / 21.0% Mo - 0.50% max. - Ni - 9.50 / 11.0% Cu - 0.50% max.						
Shielding gas		Inomaxx [®] 2						
Classification of shielding gas		EN 439 – M12						
Gas flow rate								
– Shield gas		12 l/min						
– Purge gas		n/a						
TIG electrode type		n/a						
Underside protection		n/a						
Preheat temperature		Ambient						
Interpass temperature		n/a						
Heat treatment		n/a						

Stand off distance	15 mm
Torch angle	15° in the direction of welding
Nozzle bore diameter	20 mm

*n/a: not applicable

Welding sequence



Macrography



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