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.

Features/benefits
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
Welding Process: GMAW (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
Composition: C–0.03% 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: 1/4" (6mm)
Outside Diameter: n/a
Welding Position: 1F

Welding Details

<table>
<thead>
<tr>
<th>Run</th>
<th>Process</th>
<th>Diameter of Filler Metal (inch)</th>
<th>Current (A)</th>
<th>Voltage (V)</th>
<th>Type of Current &amp; Polarity</th>
<th>Wire Feed Speed (IPM)</th>
<th>Travel Speed (IPM)</th>
<th>Heat Input (KJ/inch)</th>
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<tbody>
<tr>
<td>1</td>
<td>GMAW (MAG)</td>
<td>.040</td>
<td>240</td>
<td>27</td>
<td>DC+</td>
<td>531</td>
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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: 35 CFH
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: 5/8"
Torch Angle: 15° in the Direction of Welding
Nozzle Bore Diameter: 3/4"

* n/a: not applicable

Macrography

Welding Sequence
1 Single Pass

For more information, please contact us at:

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