



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

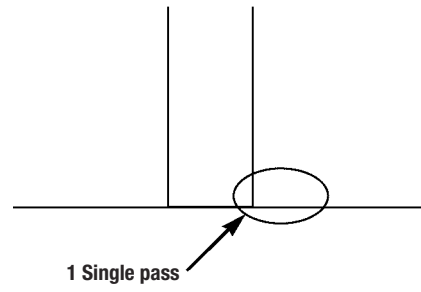
Run	Process	Diameter of filler metal (mm)	Current (A)	Voltage (V)	Type of Wire feed Current & Polarity	Wire feed Speed (m/min)	Travel Speed (mm/min)	Heat Input (KJ)
1	MAG	1.0	240	27	DC+	13.5	335	1.16
2								
3								
4								
5								
6								

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

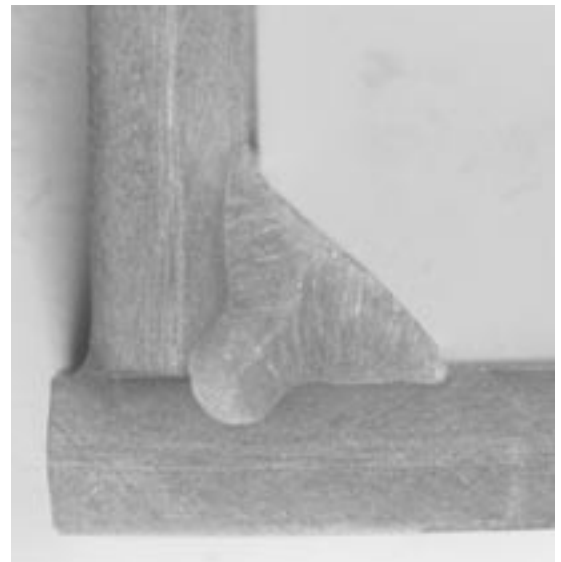
Stand off distance	15 mm
Torch angle	15° in the direction of welding
Nozzle bore diameter	20 mm

*n/a: not applicable

Welding sequence



Macrography



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