

# Inomaxx<sup>®</sup> 2



## Maximum performance for welding stainless steel



### Features/benefits

Inomaxx 2 is a mixture of argon and CO<sub>2</sub> 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

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.



## 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 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	1/4" (6mm)
Outside Diameter	n/a
Welding Position	1F

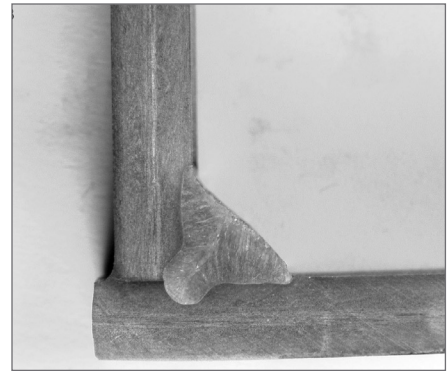
### Welding Details

Run	Process	Diameter of Filler Metal (inch)	Current (A)	Voltage (V)	Type of Current & Polarity	Wire Feed Speed (IPM)	Travel Speed (IPM)	Heat Input (KJ/inch)
1	GMAW (MAG)	.040	240	27	DC+	531	13	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.

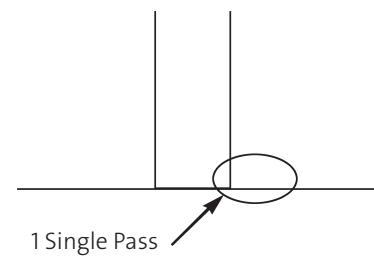
Shielding Gas	Inomaxx 2
Classification of Shielding Gas	EN 439-M12
Gas Flow Rate	
Shield Gas	35 CFH
Purge Gas	n/a
TIG Electrode Type	n/a
Underside Protection	n/a
Preheat Temperature	Ambient
Interpass Temperature	n/a
Heat Treatment	n/a
Stand Off Distance	5/8"
Torch Angle	15° in the Direction of Welding
Nozzle Bore Diameter	3/4"

\*n/a : not applicable



Macrography

### Welding Sequence



For more information,  
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