

# WELDING PARAMETERS FOR DUPLEX STAINLESS STEELS

Virtually all welding processes used on austenitic stainless steels are applicable to duplex stainless steels. This includes Gas Tungsten Arc Welding (GTAW, TIG), Gas Metal Arc Welding (GMAW, MIG), Shielded Metal Arc Welding (SMAW, "stick"), Flux Core Wire Welding (FCW), Submerged Arc Welding (SAW), and Plasma Arc Welding (PAW). Oxyacetylene welding should not be used because of the associated carbon contamination of the weld.

## Filler Metals

Most filler metals for duplex stainless steel welding are described as "matching", but typically they are overalloyed in nickel with respect to the wrought products that they are said to match. Usually there is about 2-4% more nickel than in the base metal. The nitrogen content is typically slightly lower in the weld metal than in the base metal. It is generally accepted that the more highly alloyed duplex stainless steel weld fillers are suitable for welding the lower alloyed duplex stainless steel products. The "matching" fillers have been reported to give acceptable results when joining duplex stainless steels to austenitic stainless steels or to carbon and alloy steels.

## Preheating

As a general rule, preheating is not recommended because it may be detrimental. It should not be a part of a procedure unless there is a specific justification. Preheating may be beneficial when used to eliminate moisture from the steel as may occur in cold ambient conditions or from overnight condensation. When preheating to deal with moisture, the steel should be heated to about 95°C (200°F) uniformly and only after the weld preparation has been cleaned.

## Heat Input and Interpass Temperature

Duplex stainless steels can tolerate relatively high heat inputs. The duplex solidification structure of the weld metal is more resistant to hot cracking than that of austenitic weld metals. Because duplex stainless steels have higher thermal conductivity and lower coefficient of thermal expansion than austenitic stainless steels, they have less tendency to warp during welding. While it is necessary to limit the severity of restraint on the weld, hot cracking is not a common problem.

Exceedingly low heat input may result in fusion zones and heat-affected zones which are excessively ferritic with a corresponding loss of toughness and corrosion resistance. Exceedingly high heat input increases the danger of forming intermetallic phases.

The maximum interpass temperature should be no higher than 150°C (300°F). Electronic temperature probes and thermocouples are the preferred instruments for monitoring the interpass temperature. When a large amount of welding is to be performed, planning the welding so there is enough time for cooling between passes is good, economical practice.

## Postweld Heat Treatment

Postweld stress relief is not needed for duplex stainless steels and is likely to be harmful because the heat treatment may precipitate intermetallic phases or alpha prime (475°C/885°F) embrittlement causing a loss of toughness and corrosion resistance.

Any postweld heat treatment should be a full solution anneal followed by water quenching. See Shop Sheet 101.

# Welding Parameters For Duplex Stainless Steels Molybdenum

**LL Leslie**

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**Weld Integrity and Performance** Steve Lampman, ASM International, 1997-01-01

**Uhlig's Corrosion Handbook** R. Winston Revie, 2011-04-12 This book serves as a reference for engineers scientists and students concerned with the use of materials in applications where reliability and resistance to corrosion are important It updates the coverage of its predecessor including coverage of corrosion rates of steel in major river systems and atmospheric corrosion rates the corrosion behavior of materials such as weathering steels and newer stainless alloys and the corrosion behavior and engineering approaches to corrosion control for nonmetallic materials New chapters include high temperature oxidation of metals and alloys nanomaterials and dental materials anodic protection Also featured are chapters dealing with standards for corrosion testing microbiological corrosion and electrochemical noise

**Stainless Steels** Joseph R. Davis, 1994-01-01 ASM Specialty Handbook Stainless Steels The best single volume reference on the metallurgy selection processing performance and evaluation of stainless steels incorporating essential information culled from across the ASM Handbook series Includes additional data and reference information carefully selected and adapted from other authoritative ASM sources

**Alloy Digest Sourcebook** Joseph R. Davis, 2000-01-01 This reference documents ferrous alloy development as presented in Alloy Digest since 1952 Its concise data sheet summaries which run about two pages provide material composition properties heat treatment fabrication characteristics product forms and applications Following a general overview

**Arc Welding Processes Handbook** Ramesh Singh, 2021-10-12 ARC WELDING PROCESSES HANDBOOK An applied reference each part of this Handbook gives valuable information regarding the industry or industries where the process is commonly used as well as a description of the equipment Written by a welding metallurgical engineer with over 40 years of experience Arc Welding Processes Handbook delivers the welding and materials expertise required to master complex welding processes and techniques to ensure that the task is done correctly and safely while reinforcing an understanding of international welding standards and rules The perfect handbook for those professionals who need an up to date reference to advance processes as well as those welders new to the field and need to hone their skills Arc Welding Processes Handbook five part treatment starts with a clear and rigorous exposition of the applications and equipment of Shielded Metal Arc Welding SMAW and Gas Tungsten Arc Welding GTAW followed by self contained parts concerning processes applications and equipment for Gas Metal Arc Welding GMAW Flux Core Arc Welding FCAW and Submerged Arc welding SAW An applied reference each Part of Arc Welding Processes Handbook offers valuable information regarding the industry or industries where the process is commonly used as well as a description of the

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**Stainless Steels for Design Engineers** Michael F. McGuire, 2008 The rate of growth of stainless steel has outpaced that of other metals and alloys and by 2010 may surpass aluminum as the second most widely used metal after carbon steel The 2007 world production of stainless steel was approximately 30 000 000 tons and has nearly doubled in the last ten years This growth is occurring at the same time that the production of stainless steel continues to become more consolidated One result of this is a more widespread need to understand stainless steel with fewer resources to provide that information The concurrent technical evolution in stainless steel and increasing volatility of raw material prices has made it more important for the engineers and designers who use stainless steel to make sound technical judgments about which stainless steels to use and how to use them

Marine Corrosion of Stainless Steels D. Féron, 2021-04-14 This is Number 33 of the Marine Corrosion of Stainless Steels a publication of the European Federation of Corrosion EFC Part I of this volume on the Marine Corrosion of Stainless Steels consists of five chapters and is concerned with tests that were conducted in the 1990s on the corrosivity of European sea waters Atlantic Baltic English Channel Mediterranean and North Sea towards three types of stainless steels Results from these two test programmes were presented at a European Workshop on Sea Water Corrosion of Stainless Steels in Trondheim in 1996 and at various corrosion conferences mostly in Europe The other four chapters in Part I describe experimental procedures critical pitting temperature data crevice corrosion results and results from the MAST biofilm studies The remaining 23 chapters of the book are concerned with reviews and reports that develop the above topics

*Comprehensive Materials Processing*, 2014-04-07 Comprehensive Materials Processing Thirteen Volume Set provides students and professionals with a one stop resource consolidating and enhancing the literature of the materials processing and manufacturing universe It provides authoritative analysis of all processes technologies and techniques for converting industrial materials from a raw state into finished parts or products Assisting scientists and engineers in the selection design and use of materials whether in the lab or in industry it matches the adaptive complexity of emergent materials and processing technologies Extensive traditional article level academic discussion of core theories and applications is supplemented by applied case studies and advanced multimedia features Coverage encompasses the general categories of

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**Applied Welding Engineering** Ramesh Singh,2011-09-30 Applied Welding Engineering Processes Codes and Standards is designed to provide a practical in depth instruction for the selection of the materials incorporated in the joint joint inspection and the quality control for the final product Welding Engineers will also find this book a source for developing new welding processes or procedures for new materials as well as a guide for working closely with design engineers to develop efficient welding designs and fabrication procedures

**Integrated Maintenance and Energy Management in the Chemical Industries** Kiran R. Golwalkar,2019-11-22 This book provides guidelines to ensure a safe and smooth running chemical production plant It presents in detail such important considerations as selection of proper technology with efficient machinery for a new plant or expansion diversification of existing plants for manufacture of more products for safe and pollution free operation This book also provides guidelines for improved plant layout and selection of raw materials to reduce pre processing costs prior to feeding to process units The book further examines procuring better inputs such as catalysts filter cloths tower internals etc required for smooth plant operation and better product quality for client satisfaction enhanced process control through suitable instrumentation and preventive maintenance Typical conflicts arising in production units due to different priorities among sales departments purchasing departments production engineers and maintenance engineers are addressed The book also suggests methods to reduce the loss of energy during start up and shutdowns increase equipment life and prevent environmental pollution Case studies are included in appropriate chapters

Corrosion Tests and Standards Robert Baboian,2005

Recent Trends in Material Processing, Characterization and Applications Anil Kumar Singla,Amandeep Singh Shahi,Sanjeev Katoch,2025-08-28 This book presents select proceedings of the Advanced and Emerging Materials for Technological Applications AEMTA 2024 and covers topics in engineering material their processing properties and applications The topics covered include modeling and simulation of mechanical systems mechanical design additive manufacturing advance manufacturing processes material processing surface engineering and performance of engineering structure The book is a valuable reference for researchers and professionals interested in mechanical engineering materials design and advanced manufacturing process

Heat Exchanger Design Handbook, Second Edition Kuppan Thulukkanam,2013-05-20 Completely revised and updated to reflect current advances in heat exchanger technology Heat Exchanger Design Handbook Second Edition includes enhanced figures and thermal effectiveness charts tables new chapter and additional topics all while keeping the qualities that made the first

edition a centerpiece of information for practicing engineers research engineers academicians designers and manufacturers involved in heat exchange between two or more fluids See What's New in the Second Edition Updated information on pressure vessel codes manufacturer's association standards A new chapter on heat exchanger installation operation and maintenance practices Classification chapter now includes coverage of scrapped surface graphite coil wound microscale and printed circuit heat exchangers Thorough revision of fabrication of shell and tube heat exchangers heat transfer augmentation methods fouling control concepts and inclusion of recent advances in PHEs New topics like EMbaffle Helixchanger and Twistedtube heat exchanger feedwater heater steam surface condenser rotary regenerators for HVAC applications CAB brazing and cupro braze radiators Without proper heat exchanger design efficiency of cooling heating system of plants and machineries industrial processes and energy system can be compromised and energy wasted This thoroughly revised handbook offers comprehensive coverage of single phase heat exchangers selection thermal design mechanical design corrosion and fouling FIV material selection and their fabrication issues fabrication of heat exchangers operation and maintenance of heat exchangers all in one volume      Metallic Materials Philip A. Schweitzer, P.E.,2003-01-07

Metallic Materials compares and contrasts the corrosion resistance of wrought stainless steel and high nickel alloys and explores recent advances in the production of exotic metals It emphasizes the physical and mechanical properties corrosion resistance workability and cost of various metals The authors analyze the physical and mechanical properties of metals define relevant terminology describe the various forms of corrosion to which metals may be susceptible examine wrought ferrous metals alloys and typical applications and cover wrought nickel and high nickel alloys This is a handy reference for the busy engineer and student in corrosion materials chemical mechanical civil design process metallurgical manufacturing and industrial engineering      Austenitic Stainless Steels Wojciech Borek,Tomasz Tański,Zbigniew Brytan,2017-12-20

Stainless steel is still one of the fastest growing materials Today the austenitic stainless steel with the classic composition of 18% Cr and 8% Ni grade 304L is still the most widely used by far in the world The unique characteristic of stainless steel arises from three main factors The versatility results from high corrosion resistance excellent low and high temperature properties high toughness formability and weldability The long life of stainless steels has been proven in service in a wide range of environments together with low maintenance costs compared to other highly alloyed metallic materials The retained value of stainless steel results from the high intrinsic value and easy recycling Stainless steel especially of austenitic microstructure plays a crucial role in achieving sustainable development nowadays so it is also important for further generations      Architectural Design in Steel Mark Lawson,Peter Trebilcock,2004-08-02

A design guide to the detailing of exposed steelwork in buildings Written specifically for architects this guide offers technical guidance general principles as well as examples of best practice      **Latest Trends in Engineering and Technology** Sajjan Singh,Sarabpreet Kaur,2024-06-28 We are very pleased to introduce the proceedings of the International Conference on Latest Trends in

Engineering and Technology ICLTET 2023 Papers were well presented in the conference in the fields of Artificial Intelligence Machine learning IOT Communication Networks Mechanical Engineering Civil Engineering Nano Material Research Business Management and many more to arouse a high level of interest The presented papers maintained the high promise suggested by the written abstracts and the program was chaired in a professional and efficient way by the session chair who were selected for their expertise in the subject The number of delegates was also highly gratifying showing the high level of interest in the subject This Proceeding provides the permanent record of what was presented They indicate the state of development at the time of writing of all aspects of this important topic and will be invaluable to all academicians and researchers in the field for that reason Finally it is appropriate that we record our thanks to our fellow members of the Technical Organizing Committee for encouraging participation from those areas We are also indebted to those who served as session chair and reviewers without their support the conference could not have been the success that it was We also acknowledge the authors themselves without whose expert input there would have been no conference Their efforts made a great contribution to its success

**Welding and Metal Fabrication** ,1990      Materials Selection for Corrosion Control  
Sohan L. Chawla,1993-01-01 Provides a methodology for integrating materials selection with the design process including simultaneous technical and economic evaluation Save hours of frustrating research time Get fast answers about the best material for a particular application In the past researching the endless sources on corrosion and materials in their countless applications were next to impossible That s why this book was written to help simplify your materials selection problems It s an exhaustive source on the different corrosion resistant materials types of corrosion factors affecting corrosion passivation corrosion monitoring corrosion control measures methodology of materials selection and more

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## **Table of Contents Welding Parameters For Duplex Stainless Steels Molybdenum**

1. Understanding the eBook Welding Parameters For Duplex Stainless Steels Molybdenum
  - The Rise of Digital Reading Welding Parameters For Duplex Stainless Steels Molybdenum
  - Advantages of eBooks Over Traditional Books
2. Identifying Welding Parameters For Duplex Stainless Steels Molybdenum
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Welding Parameters For Duplex Stainless Steels Molybdenum
  - User-Friendly Interface
4. Exploring eBook Recommendations from Welding Parameters For Duplex Stainless Steels Molybdenum
  - Personalized Recommendations
  - Welding Parameters For Duplex Stainless Steels Molybdenum User Reviews and Ratings
  - Welding Parameters For Duplex Stainless Steels Molybdenum and Bestseller Lists
5. Accessing Welding Parameters For Duplex Stainless Steels Molybdenum Free and Paid eBooks
  - Welding Parameters For Duplex Stainless Steels Molybdenum Public Domain eBooks
  - Welding Parameters For Duplex Stainless Steels Molybdenum eBook Subscription Services
  - Welding Parameters For Duplex Stainless Steels Molybdenum Budget-Friendly Options



6. Navigating Welding Parameters For Duplex Stainless Steels Molybdenum eBook Formats
  - ePub, PDF, MOBI, and More
  - Welding Parameters For Duplex Stainless Steels Molybdenum Compatibility with Devices
  - Welding Parameters For Duplex Stainless Steels Molybdenum Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Welding Parameters For Duplex Stainless Steels Molybdenum
  - Highlighting and Note-Taking Welding Parameters For Duplex Stainless Steels Molybdenum
  - Interactive Elements Welding Parameters For Duplex Stainless Steels Molybdenum
8. Staying Engaged with Welding Parameters For Duplex Stainless Steels Molybdenum
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Welding Parameters For Duplex Stainless Steels Molybdenum
9. Balancing eBooks and Physical Books Welding Parameters For Duplex Stainless Steels Molybdenum
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Welding Parameters For Duplex Stainless Steels Molybdenum
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Welding Parameters For Duplex Stainless Steels Molybdenum
  - Setting Reading Goals Welding Parameters For Duplex Stainless Steels Molybdenum
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Welding Parameters For Duplex Stainless Steels Molybdenum
  - Fact-Checking eBook Content of Welding Parameters For Duplex Stainless Steels Molybdenum
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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