

EDMESTON

SX[®] Welding Material

Sandvik SX[®] stainless steel was introduced to the market by Edmeston AB in 1984. The introduction of Sandvik SX[®] equipment led to a paradigm change in the industry with equipment of reduced corrosion, prolonged life, reduced maintenance and increased plant safety. Sandvik SX[®] is maintaining the leading position as the number one, standard for comparison, top performing alloy, for sulphuric acid service.

WELDING SANDVIK SX[®] - GUIDELINES

Sandvik SX[®]:

A fully austenitic stainless steel material

Welding process:

The following welding methods can be applied welding Sandvik SX[®] : SMAW, GTAW, GMAW and PAW.

Welding deformation:

Welding deformation of Sandvik SX[®] is slightly higher compared to standard grade stainless material.

Welding Sandvik SX[®] to other materials:

Sandvik SX[®] can be welded to other materials such as carbon steel and stainless steel. Welding SX to Ni-based material (> 30% Ni) is however critical.

Important recommendations for welding Sandvik SX[®]

1. Always use Sandvik SX[®] filler material.
2. When welding Sandvik SX[®] to other materials, use Sandvik SX[®] filler material.
3. Sandvik SX[®] shall be welded with low input (Max 1,0 kJ/mm).
4. Max inter pass temperature is 60⁰ C / 140⁰ F.

Welding Procedure Specifications (WPS) are available from Edmeston, on request.



WELD ELECTRODES, SMAW

Dia (mm)	Weight/Pack. (kg)	Stock Material
2.0	3.6	Yes
2.5	3.6	Yes
3.25	4.1	Yes
4.0	4.5	Yes

TIG RODS, GTAW

Dia (mm)	Weight/Pack. (kg)	Stock Material
2.0	5.0	Yes
2.4	5.0	Yes
3.25	5.0	Yes

MIG WIRE, GMAW

Dia (mm)	Weight/Pack. (kg)	Stock Material
0.9	15.0	Yes
1.14	15.0	Yes
1.6	15.0	Yes



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