

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.

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