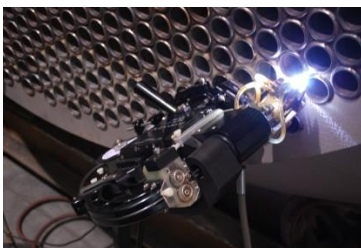


Noram SX™ Welding

Noram SX™ is the trademark for the austenitic stainless steel, UNS S32615, which was developed by Sandvik in Sweden specifically for the use in hot concentrated Sulphuric Acid. SX steel is considered the benchmark in sulphuric acid service with over 25 years of unparalleled performance offering numerous advantages over other materials of construction.



Guideline for Welding NORAM SX™

NORAM SX™ is a fully austenitic stainless steel material.

Welding Process

The following welding methods can be applied welding NORAM SX™: SMAW, GTAW, GMAW and PAW.

Welding deformation

Welding deformation of NORAM SX™ is slightly higher compared to standard grade stainless steel.

Welding NORAM SX™ to other materials

NORAM 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 NORAM SX™

1. Always use NORAM SX™/Sandvik SX® filler material
2. When welding NORAM SX™ to other materials, use Sandvik SX®
3. Sandvik SX® shall be welded with low input (Max 1,0 kJ/mm)
4. Max inter pass temperature is 60o C / 140o F

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

Sandvik SX® TIG Rods, GTAW

2.0 mm	5 kg/pack
2.4 mm	5 kg/pack
3.25 mm	5 kg/pack

Sandvik SX® MIG Wire, GMAW

0.9 mm	15 kg/pack
1.14 mm	15 kg/pack
1.6 mm	15 kg/pack

NORAM SX™ Welding Electrodes, SMAW

2.0 mm	2.5 kg/pack
2.5 mm	2.5 kg/pack
3.25 mm	3 kg/pack

