



# Installation

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## Pipe Welding Guidelines

### Carbon Steel Piping to Stainless Piping

Model: ABDA, KIT09711



# General Information

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## Literature change history

PART-SVN91A-EN (April 2005) manual first release.

## About this manual

This KIT09711 is a piping weld assembly used on ABDA units.

The purpose of this publication is to provide general information for carbon steel to stainless steel welds. It applies to the listed kit but can also be applied to other carbon steel to stainless joints.

This information is not the controlling document. It is the responsibility of the party coordinating the repair to provide qualified procedures and welders.

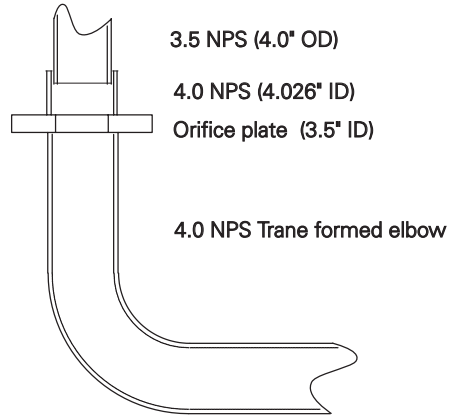
## General information

This information is not a welding procedure. Welding should be performed by a qualified welder. The following information is provided to assist the weld technician.

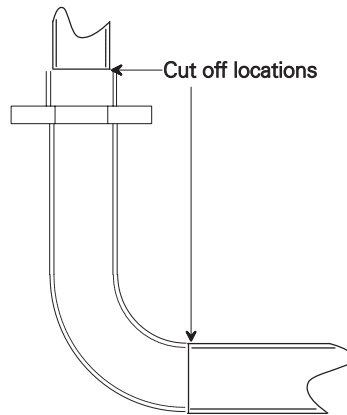
### Carbon Steel to 316 Stainless Steel

- Filler metals, AWS# E309L-15 or E309L-16, size 3/32" through 3/16" diameter.
- Minimum temperature of base metal before welding, 50° F.
- Electrical characteristics, direct current electrode positive.
- Cleanliness prior to welding:base metal must be clean of all dirt, grease, and oil.
- Interpass cleaning,wire brush between all passes.
- Method of backgouging,thermal or mechanical.
- Tack welds, grind the start and stop of all tack welds.

**Figure 1. Original piping layout with carbon steel**

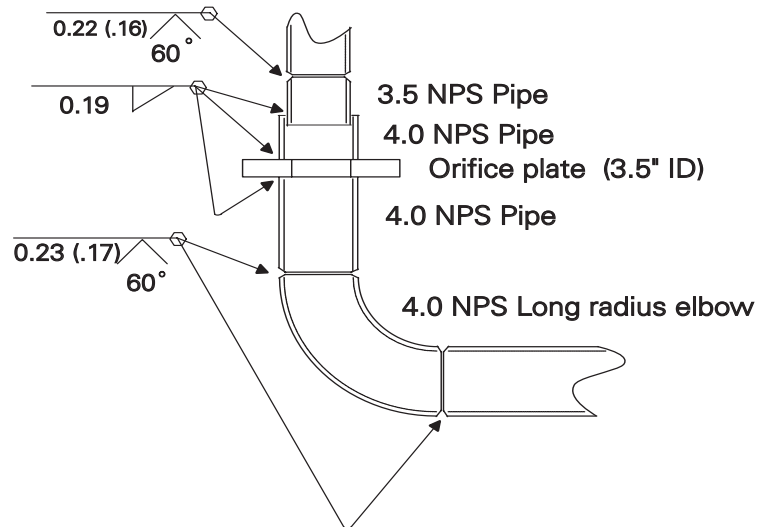


**Figure 2. Cut off locations when removing elbow**



Using the 309L stainless filler material on the 316L base metal use the following figure as an example of recommended welds.

**Figure 3. Stainless to carbon pipe weld graphic**





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