



# WELDING RINGS

## FOR STAINLESS STEEL

For the highest quality when welding tubes and fittings for the  
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Product safety comes first in the manufacture of pharmaceutical substances. To ensure the highest purity standards at the weld seam too, seam impurities formed during the regular welding process must be minimized.

## PROCESSING OF 1.4404/1.4435 (316L)

Ferrite is a metallic structure that may form when welding 1.4404 / 1.4435 (316L) and may impair corrosion resistance.

Welding rings from Dockweiler substantially reduce ferrite formation, ensuring a content of less than 3%.

## PROCESSING OF 1.4539 (904L)/AL-6XN

With higher-alloyed materials such as 1.4539 (904L) and AL-6XN, undesirable constituents such as sigma phase form during welding. Alloying elements such as chromium and molybdenum accumulate here. This process reduces corrosion resistance and mechanical strength in adjacent areas.

The use of welding rings minimizes any impact and ensures a safe connection.

Material to be welded	Welding ring material	Nominal sizes	
		Imperial	ISO
1.4435 / UNS S31603 (316L)	1.4539 / UNS N08904 (904L)	½" up to 2 ½"	13,5 mm – 88,9 mm
1.4404 / UNS S31603 (316L)	1.4539 / UNS N08904 (904L)	½" up to 2 ½"	13,5 mm – 88,9 mm
1.4539 / UNS N08904 (904L)	C22	½" up to 2 ½"	13,5 mm – 88,9 mm
AL-6XN	C22	½" up to 2 ½"	13,5 mm – 88,9 mm

## THE ADVANTAGES OF DOCKWEILER WELDING RINGS AT A GLANCE:

- Highest quality standards** Dockweiler welding rings are the perfect match for welding our pipes and fittings
- Safe processing** Dockweiler welding rings are ideal for orbital welding
- Everything from a one-stop provider** As soon as you buy tubes and fittings, you can order the additional welding rings you actually require
- Accessible documentation** All Dockweiler welding rings have certification that is also available via our WebCert System



Dockweiler AG

An der Autobahn 10/20, 19306 Neustadt-Glewe, Germany

Tel. + 49 38757 58 0, Fax: + 49 38757 58 222, E-Mail: sales@dockweiler.com, Internet: www.dockweiler.com



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