

## **LIST OF TABLES**

<b>TABLE NO</b>	<b>TITLE</b>	<b>PAGE NO.</b>
<b>2.1</b>	<b>Chemical compositions of commonly used Duplex SS and other alloys</b>	<b>11</b>
<b>2.2</b>	<b>Standard compositions of some commonly used Duplex Stainless steels</b>	<b>12</b>
<b>2.3</b>	<b>Physical Properties of Duplex Stainless steels</b>	<b>12</b>
<b>2.4</b>	<b>As per ASTM &amp; EN Mechanical property limits for Duplex SS Plate</b>	<b>13</b>
<b>2.5</b>	<b>Min values according to EN 10028, Transverse direction</b>	<b>13</b>
<b>2.6</b>	<b>The role of alloying elements in Duplex Stainless Steels can be summarized as below</b>	<b>23</b>
<b>2.7</b>	<b>Welding Consumables Used for Dissimilar Metal Welding</b>	<b>28</b>
<b>2.8</b>	<b>Suitable Welding process recommendations</b>	<b>30</b>
<b>2.9</b>	<b>Recommendations for DSS welding consumables</b>	<b>30</b>
<b>2.10</b>	<b>The temperature limits for duplex stainless steel Precipitation temperature for DSS</b>	<b>45</b>
<b>2.11</b>	<b>Comparative Stress Corrosion cracking resistance in accelerated laboratory tests</b>	<b>59</b>
<b>3.1</b>	<b>Chemical Composition of UNS S31803 as per PMI Spectroscopy</b>	<b>61</b>
<b>3.2</b>	<b>Physical Properties of Duplex Stainless steels</b>	<b>62</b>
<b>3.3</b>	<b>As per ASTM &amp; EN Mechanical property limits for Duplex SS Plate</b>	<b>62</b>
<b>3.4</b>	<b>Min values according to EN 10028, Transverse</b>	<b>63</b>

	<b>direction</b>	
<b>3.5</b>	<b>Chemical compositions of the undiluted weld metals carried out on weld pad as per ASME SEC II C</b>	<b>64</b>
<b>3.6</b>	<b>Dimension of all weld test coupon set up</b>	<b>66</b>
<b>3.4.5.1</b>	<b>DATA SHEET Test Coupon Preparation E2209-16 (9 Ni 22 Cr)</b>	<b>70</b>
<b>3.4.5.2</b>	<b>DATA SHEET Test Coupon Preparation 10 Ni 22 Cr</b>	<b>71</b>
<b>3.4.5.3</b>	<b>DATA SHEET Test Coupon Preparation 11 Ni 22 Cr</b>	<b>72</b>
<b>3.4.5.4</b>	<b>DATA SHEET Test Coupon Preparation 12 Ni 22 Cr</b>	<b>73</b>
<b>3.5.1.</b>	<b>Test Plan for Weld Coupon Prepared by E 2209-16 (9 Ni22Cr)</b>	<b>74</b>
<b>3.5.2.</b>	<b>Test Plan for Weld Coupon Prepared by E 2209-16 (10Ni22Cr)</b>	<b>75</b>
<b>3.5.3.</b>	<b>Test Plan for Weld Coupon Prepared by E 2209-16 (11Ni22Cr)</b>	<b>76</b>
<b>3.5.4.</b>	<b>Test Plan for Weld Coupon Prepared by E 2209-16 (12Ni22Cr)</b>	<b>77</b>
<b>4.1.</b>	<b>All weld Tensile Test method as per AWS B4.0</b>	<b>102</b>
<b>4.2</b>	<b>Transverse Rectangular Tension Test Specimen (Plate)</b>	<b>106</b>
<b>4.3</b>	<b>Welded coupon Micro Hardness Profile as per E-384, EN ISO-9015-1:2011</b>	<b>106</b>
<b>4.4</b>	<b>CVN Results at Test Temperature (°C) -46° C</b>	<b>108</b>
<b>4.5</b>	<b>Chemical Composition of UNS S32205 as per PMI Spectroscopy</b>	<b>109</b>

<b>4.6</b>	<b>Chemical compositions of the undiluted weld metals carried out on weld pad as per ASME SEC II C.</b>	<b>109</b>
<b>4.7</b>	<b>WM FN 31.54 (Ni = 9.5-10.5%) Fischer Make Feritscope®</b>	<b>125</b>
<b>4.8</b>	<b>WM FN 27.6 (Ni = 10.5-11.5%) Fischer Make Feritscope®</b>	<b>125</b>
<b>4.9</b>	<b>WM FN 14.4 (Ni = 11.5-12.5%) Fischer Make Feritscope®</b>	<b>125</b>
<b>4.10</b>	<b>Pitting corrosion results as per ASTM G48 Method A</b>	<b>126</b>
<b>5.1</b>	<b>All weld metal test results are tabulated as below</b>	<b>130</b>
<b>5.2</b>	<b>FN measurement results of WRC-1992 (predicted value) and Feritscope Instrument (measured value) for all weld compositions</b>	<b>145</b>
<b>5.3</b>	<b>ASTM G48A pitting test results</b>	<b>145</b>
<b>5.4</b>	<b>Periodic observation of CSSC Samples at bend portion 20 X magnification</b>	<b>146</b>