

| Condition   | Chloride ppm | Mild                      |     | Moderate                                |       | Severe                                  |        | Very Severe          |         |          |
|-------------|--------------|---------------------------|-----|---|-------|---|--------|----------------------|---------|----------|
|             |              | 100                       | 500 | 1,000                                   | 5,000 | 10,000                                  | 30,000 | 70,000               | 100,000 | 200,000  |
|             | pH           | 316L Type Stainless Steel |     | 904L or Duplex 2205                     |       | 904L, Duplex 2205, MaxCore 6MO or AL6XN |        | MaxCore 6MO or AL6XN |         | Alloy 22 |
| Mild        | 6.5          | 316L Type Stainless Steel |     | 904L or Duplex 2205                     |       | 904L, Duplex 2205, MaxCore 6MO or AL6XN |        | MaxCore 6MO or AL6XN |         |          |
| Moderate    | 4.5          | 316L Type Stainless Steel |     | 904L, Duplex 2205, MaxCore 6MO or AL6XN |       | 904L, Duplex 2205, MaxCore 6MO or AL6XN |        | MaxCore 6MO or AL6XN |         |          |
| Severe      | 2            | 904L or Duplex 2205       |     | MaxCore 6MO or AL6XN                    |       | MaxCore 6MO or AL6XN                    |        | MaxCore 6MO or AL6XN |         |          |
| Very Severe | 1            | 904L or Duplex 2205       |     | MaxCore 6MO or AL6XN                    |       | MaxCore 6MO or AL6XN                    |        | MaxCore 6MO or AL6XN |         |          |

**Guidelines for Selection of Stainless Steels and Nickel Alloys Based Upon Chloride Content and pH (150-180 Deg F)**

This chart is not intended to limit the use of other materials that may perform adequately in these service conditions.

This chart is for reference only. Users are encouraged to seek guidance from a reputable materials professional for verification of proper alloy selection.

6Mo alloys can be successfully welded to 316L, Duplex materials and nickel alloys. Weld rings are required when field welding 6Moly alloys or Duplex materials.

| Type        | UNS Number Cross Reference | Similar EN Grade |
|-------------|----------------------------|------------------|
| 316L        | S31603                     | 1.4404           |
| 904L        | N08904                     | 1.4439           |
| Duplex 2205 | S32205                     | 1.4462           |
| MaxCore 6MO | N08367                     | 1.4529           |
| AL6XN       | N08367                     | 1.4529           |
| Alloy 22    | N06022                     | 2.4602           |