BÖHLER FOX EAS 2-A

Covered electrode, high-alloyed, austenitic stainless

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 19 9 L R 3 2	E308L-17

Characteristics and typical fields of application

Rutile coated, core wire alloyed electrode of E 19 9 L R / E308L-17 type. Preferably used for 1.4306 / 304L and 304LN steel grades. Designed for first class weld seams and easy handling on AC or DC. High current carrying capacity with minimum spatter formation. Self-releasing slag, smooth and clean weld profile. Max. service temperature 350ºC.

Base materials

1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4307 X2CrNi18-9, 1.4311 X2CrNiN18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10
UNS S30400, S30403, S30453, S32100, S34700
AISI 304, 304L, 304LN, 302, 321, 347

Typical analysis

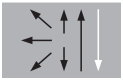
	C	Si	Mn	Cr	Ni
wt.-%	0.03	0.8	0.8	19.8	10.2

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact energy ISO-V KV J		
	MPa	MPa	%	20°C	–120°C	–196°C
u	430 (≥ 320)	580 (≥ 520)	45 (≥ 30)	75	43 (≥ 32)	
as						34 (≥ 32)

u untreated, as-welded
as solution annealed and quenched

Operating data



Polarity	DC+ / AC
Electrode identification	FOX EAS 2-A 308L-17 E 19 9 L R

Dimension mm	Current A
1.5 × 250	25 – 40
2.0 × 300	40 – 60
2.5 × 350	50 – 90
3.2 × 350	80 – 120
4.0 × 350	110 – 160
5.0 × 450	140 – 200

Suggested heat input is max. 2.0 kJ/mm and interpass temperature max. 150ºC.
Redrying if necessary at 250 – 300ºC for min. 2 h.

Approvals

TÜV (01095), DB (30.014.15), ABS, DNV, CWB, CE