BÖHLER FOX EAS 2-A

Rutile stick electrode, high-alloyed, stainless

Classifications

EN ISO 3581-A	EN ISO 3581-B	AWS A5.4
E 19 9 L R 3 2	ES308L-16	E308L-17

Characteristics and typical fields of application

Rutile electrode, core wire alloyed, stainless steel. Preferably used for 1.4306 / 304L / 304LN steel grades. BÖHLER FOX EAS 2-A is noted for its superior welding characteristics and metallurgy. Can be used on AC or DC. Other characteristics include high current carrying capacity, minimum spatter formation, self-releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins.

Resistant to intergranular corrosion up to +350 °C.

Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10, 1.4312 G-X10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10

AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of all-weld metal (wt.-%)

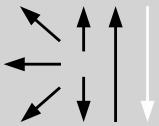
	C	Si	Mn	Cr	Ni
wt.-%	0.03	0.8	0.8	19.8	10.2

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	–120 °C	–196 °C
u	**430** (≥ 320)	**560** (≥ 520)	**40** (≥ 30)	**70**	≥ 32	
sa						≥ 32

u untreated, as welded
sa solution annealed and quenched

Operating data



Polarity:	Redrying if necessary:	Electrode identification:	ø (mm)	L mm	Amps A
DC (+)	120 – 200 °C, min. 2 h	FOX EAS 2-A 308L-17 E 19 9 L R	1.5	250	25 – 40
AC			2.0	300	40 – 60
			2.5	250/350	50 – 90
			3.2	350	80 – 120
			4.0	350	110 – 160
			5.0	450	140 – 200

Approvals

TÜV (1095.), DB (30.014.15), ABS (E 308L-17), GL (4306), Statoil, VUZ, SEPROZ, CE, CWB, NAKS (ø 3.2 mm; ø 4.0 mm)