BÖHLER FOX EAS 2-A

High alloyed stick electrode type 308L for welding of austenitic stainless steel like 1.4301 or 1.4306 or AISI 304L

Main benefit

Core wire alloyed stick electrode for very homogeneous corrosion resistance.

Product features	Product benefits	User benefits
» **Core wire alloyed coating concept**	» Homogeneous chemistry of every single stick from the beginning up to the end	» Homogeneous weld seams lead to reliable corrosion resistance
» **Designed for easy welding**	» Minimum spatter formation » Self-releasing slag	» Less post weld cleaning » Lower total welding time
» **Rutile coated**	» Easy to handle » Very good welding characteristics	» Fine ripped weld seams » Shiny surface for visible seams
» **Designed for high quality welds** » **Moisture resistant coating**	» Very good mechanical properties » Safe against porosity » Many 3rd party approvals	» Welding for high demanding industries with required approvals
» **Available in Böhler Dry System and in hermetical sealed tins**	» Ready to weld without re-drying up to 9 h after opening	» Reduced preparation work, safe packaging always dry, oven-fresh stick electrodes

Typical applications

» Chemical industry
» Food and beverage industry
» Storage tanks
» Stainless steel parts for buildings

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Classifications			Operating data	
EN ISO 3581-A	AWS A5.4 / SFA-5.4		Welding positions	Polarity
E 19 9 L R 3 2	E308L-17			

Typical analysis of all weld metal, wt. %

	C	Si	Mn	Cr	Ni
	0.03	0.80	0.80	19.80	10.2

Mechanical properties, all weld metal (single values typical)

	Condition	Yield strength $R_{p0.2\%}$ MPa	Tensile strength R_m MPa	Elongation $A (L_0 = 5d_0)$ %	CVN Impact toughness ISO-V KV J 20 °C	−120 °C	−196°C
	As welded	430 (≥ 320)	560 (≥ 520)	40 (≥ 30)	70	≥ 32	
	Solution annealed and quenched						40 (≥ 32)

Steels to be welded

EN	ASTM
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; UNS S30400, S30403, S30453, S32100, S34700 ASTM A157 Gr. C9, A320 Gr. B8C or D

Approvals

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

Tin Packaging

Weight: ~ 4.1 kg

Diameter
2.0 x 300 mm
2.5 x 350 mm
3.2 x 350 mm
4.0 x 350 mm
5.0 x 450 mm

Dry System Vacuum Packaging

Weight: DrySys 20: ~1.2 kg
DrySys 30: ~ 2.1 kg

Diameter:
2.5 x 300 mm
2.5 x 350 mm
3.2 x 350 mm
4.0 x 350 mm