



# BÖHLER FOX EAS 4 M-A

High alloyed stick electrode type 316L for welding of austenitic stainless steel like 1.4401 or 1.4404 or AISI 316L

Main benefit

Core wire Mo-alloyed stick electrode for very homogeneous corrosion resistance.

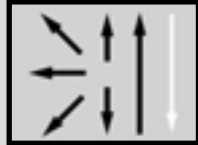
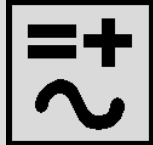
Product features	Product benefits	User benefits
» Core wire alloyed coating concept	» Homogeneous chemistry of every single stick from the beginning up to the end	» Homogeneous weld seams lead to reliable corrosion resistance
» Designed for easy welding	» Minimum spatter formation » Self-releasing slag	» 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 3 <sup>rd</sup> 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 packing 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 12 3 LR 3 2	E316L-17		

Typical analysis of all weld metal, wt. %						
	C	Si	Mn	Cr	Ni	Mo
	0.03	0.80	0.80	18.80	11.50	2.70

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
	As welded	460 (≥ 320)	600 (≥ 510)	36 (≥ 25)	70	≥ 32

Steels to be welded	
EN	ASTM
1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-13-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12, 1.4409 GX2CrNiMo 19-11-2	UNS S31603, S31653; AISI 316L, 316Ti, 316Cb

Approvals
TÜV (00773), DB (30.014.14), ABS, DNV GL, LR, Equinor, CWB, CE

Tin Packaging	Dry System Vacuum Packaging
 <p>Weight: ~ 4,1 kg</p> <p>Diameter 2.0 x 300 mm 2.5 x 300 mm 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm 5.0 x 450 mm</p>	 <p>Weight: DrySys 20: ~1.2 kg DrySys 30: ~ 2.1 kg</p> <p>Diameter: 2.5 x 300 mm 2.5 x 350 mm 3.2 x 350 mm 4.0 x 350 mm</p>