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
- Core wire alloyed coating concept
- Designed for easy welding
- Rutile coated
- Designed for high quality welds
- Moisture resistant coating
- Available in Böhler Dry System and in her-metical sealed tins

### Product benefits
- Homogeneous chemistry of every single stick from the beginning up to the end
- Minimum spatter formation
- Self-releasing slag
- Easy to handle
- Very good welding characteristics
- Very good mechanical properties
- Safe against porosity
- Many 3rd party approvals
- Ready to weld without re-drying up to 9 h after opening

### User benefits
- Homogeneous weld seams lead to reliable corrosion resistance
- Less post weld cleaning
- Lower total welding time
- Fine ripped weld seams
- Shiny surface for visible seams
- Welding for high demanding industries with required approvals
- 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
### BÖHLER FOX EAS 2-A

<table>
<thead>
<tr>
<th>Classifications</th>
<th>Operating data</th>
</tr>
</thead>
<tbody>
<tr>
<td>EN ISO 3581-A</td>
<td>AWS A5.4 / SFA-5.4</td>
</tr>
<tr>
<td>E 19 9 L R 3 2</td>
<td>E308L-17</td>
</tr>
</tbody>
</table>

#### Typical analysis of all weld metal, wt. %

<table>
<thead>
<tr>
<th>C</th>
<th>Si</th>
<th>Mn</th>
<th>Cr</th>
<th>Ni</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.03</td>
<td>0.80</td>
<td>0.80</td>
<td>19.80</td>
<td>10.2</td>
</tr>
</tbody>
</table>

#### Mechanical properties, all weld metal (single values typical)

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

#### Steels to be welded

<table>
<thead>
<tr>
<th>EN</th>
<th>ASTM</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2Cr-NiN18-10, 1.4312 G-X10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10</td>
<td>AISI 304, 304L, 304LN, 302, 321, 347; UNS S30400, S30403, S30453, S32100, S34700 ASTM A157 Gr. C9, A320 Gr. B&amp;C or D</td>
</tr>
</tbody>
</table>

#### 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