

**Classifications**

<b>EN ISO 3581-A</b>	<b>AWS A5.4 / SFA-5.4</b>
E 19 9 L B 2 2	E308L-15

**Characteristics and typical fields of application**

Basic coated, cored wire alloyed electrode of E 19 9 L B / E308L-15 type. Primarily used for 1.4306 / 304L and 304LN steel grades. Designed to produce first class weld deposits with reliable CVN impact toughness values down to  $-196^{\circ}\text{C}$ . Good gap bridging ability, very good root pass and excellent X-ray safety. Good welding characteristics in all positions except vertical-down with easy weld pool and slag control. Easy slag removal even in narrow preparations result in clean bead surfaces with minimum post-weld cleaning. Ideal electrode for welding on site. Max. service temperature  $350^{\circ}\text{C}$ . Also available as a special low ferrite version, BÖHLER FOX EAS 2 (LF).

**Base materials**

1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4311 X2CrNi18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10  
AISI 304, 304L, 304LN, 302, 321, 347

**Typical analysis**


	C	Si	Mn	Cr	Ni	FN
wt.-%	0.03	0.4	1.3	19.8	9.6	4 – 10

**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	%	$20^{\circ}\text{C}$	$-196^{\circ}\text{C}$
u	420 ( $\geq 320$ )	575 ( $\geq 520$ )	40 ( $\geq 30$ )	110	46 ( $\geq 34$ )

u untreated, as-welded

**Operating data**

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	FOX EAS 2 308L-15 E 19 9 L B	2.5 × 300	50 – 80
			3.2 × 350	80 – 110
			4.0 × 350	110 – 140
			5.0 × 450	140 – 180

Suggested heat input is max. 2.0 kJ/mm and interpass temperature max.  $150^{\circ}\text{C}$ .

**Approvals**

TÜV (00152), DB (30.014.10), CE