BÖHLER FOX EAS 4 M-A

Covered electrode, high-alloyed, austenitic stainless

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 19 12 3 L R 3 2	E316L-17

Characteristics and typical fields of application

Rutile coated, core wire alloyed electrode of E 19 12 3 L R / E316L-17 type. Preferably used for 1.4404 and 1.4435 / 316L austenitic stainless steel grades suitable in all industries using similar or high carbon steels or ferritic 13Cr-steels. Designed for first class weld seams and easy handling on AC or DC. High current carrying capacity with minimum spatter formation. Self-releasing slag, smooth and clean weld profile. Good resistance to general and pitting corrosion. Max. service temperature 400ºC.

Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2, 1.4409 GX2CrNiMo19-11-2, 1.4429 X2CrNiMoN17-12-3, 1.4432 X2CrNiMo17-12-3, 1.4435 X2CrNiMo18-14-3, 1.4436 X3CrNiMo17-12-3, 1.4571 X6CrNiMoTi17-12-2, 1.4580 X6CrNiMoNb17-12-2, 1.4583 X10CrNiMoNb18-12
UNS S31600, S31603, S31635, S31640, S31653
AISI 316L, 316Ti, 316Cb

Typical analysis

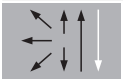
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.03	0.8	0.8	18.8	11.5	2.7

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°C	–120°C
u	460 (≥ 320)	590 (≥ 510)	41 (≥ 25)	64	50 (≥ 32)

u untreated, as-welded

Operating data



Polarity	DC+ / AC
Electrode identification	FOX EAS 4 M-A 316L-17 E 19 12 3 L R

Dimension mm	Current A
1.5 × 250	25 – 40
2.0 × 300	40 – 60
2.5 × 250	50 – 90
2.5 × 350	50 – 90
3.2 × 350	80 – 120
4.0 × 350	110 – 160
4.0 × 450	110 – 160
5.0 × 450	140 – 200

Suggested heat input is max. 2.0 kJ/mm and interpass temperature max. 150ºC.
Redrying if necessary at 250 – 300ºC for min. 2 h.

Approvals

TÜV (00773), DB (30.014.14), ABS, DNV, LR, CWB, RINA, CE