

## Classifications

<b>EN ISO 3581-A</b>	<b>AWS A5.4</b>
E 19 12 3 L R 1 2	E316L-16

## Characteristics and typical fields of application

Rutile-basic electrode, low carbon, stainless steel particularly designed for site welding of thin walled tubes and sheets.

The very stable arc produces an excellent root penetration, bead configuration and gap bridging ability on DC electrode negative even when welding with a low amperage. BÖHLER FOX EAS 4 M-TS is a good economical alternative to GTAW welding on difficult accessible on-site welding applications.

High safety against formation of porosity by moisture resistant coating and packaging into hermetically sealed tin.

The product is resistant to intergranular corrosion up to service temperatures of +400 °C.

## Base materials

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

## Typical analysis of all-weld metal (wt.-%)

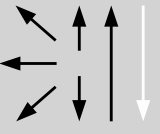
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.03	0.7	0.8	19.4	11.8	2.7

## Mechanical properties of all-weld metal

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-120 °C
u	<b>510</b> (≥ 320)	<b>630</b> (≥ 510)	<b>35</b> (≥ 25)	<b>60</b>	≥ 32

u untreated, as welded

## Operating data

	<b>Polarity:</b>	<b>Redrying if necessary:</b>	<b>Electrode identification:</b>	<b>ø (mm)</b>	<b>L mm</b>	<b>Amps A</b>
	DC ( + )	120 – 200 °C, min. 2 h	FOX EAS 4 M-TS E 19 12 3 LR	2.0	300	35 – 60
	DC ( - )			2.5	350	45 – 70
	DC negative for root pass			3.2	350	50 – 110

## Approvals

TÜV (05625.), SEPPOZ, CE