

Classifications

EN ISO 3581-A	EN ISO 3581-B	AWS A5.4
E Z19 12 3 L B 2 2	BS316L-15	E316L-15

Characteristics and typical fields of application

Basic electrode, core wire alloyed stainless steel. Preferably used for 1.4435 / 316L steel grade. Controlled delta ferrite content (3-8 FN).

BÖHLER FOX EAS 4 M (LF) is designed to produce high quality weld deposits with reliable toughness values down to -196°C . 100 % X-ray safety together with good root pass and positional welding characteristics. Good gap bridging ability, 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. Electrodes are packed in hermetically sealed tins and have a moisture resistant coating.

Resistant to intergranular corrosion up to $+400^{\circ}\text{C}$.

Base materials

1.4401 X5CrNiMo17-12-2, 1.4404 X2CrNiMo17-12-2,
1.4409 GX2CrNiMo 19-11-2
UNS S31603, S31653; AISI 316L

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

	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.03	0.4	1.2	18.5	12.8	2.4

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J			Lateral expansion n (mm)
	MPa	MPa	%	$+20^{\circ}\text{C}$	-120°C	-196°C	-196°C
u	430 (≥ 320)	570 (≥ 510)	38 (≥ 25)	100	≥ 32	55 (≥ 27)	≥ 0.38

u untreated, as welded

Operating data

	Polarity:	Electrode identification:	\varnothing (mm)	L mm	Amps A
	DC (+)	FOX EAS 4 M (LF)	2.5	300	50 – 80
		316L-15	3.2	350	80 – 110
			4.0	350	110 – 140

Approvals

DNV (316)