

Classifications

EN ISO 17633-A:	EN ISO 17633-AB	AWS A5.9	AWS A5.22
T 19 9 L M M12 2	TS308L-M M12 1	EC308L	EC308L

Characteristics and typical fields of application

Böhler EAS 2-MC is an austenitic CrNi-metal cored wire for GMAW applicable for same or similar alloyed, stabilized or non-stabilized, corrosion resistant CrNi-steels. Suitable for service temperatures from -196 °C to $+350\text{ °C}$. This product achieves high productivity and is easy to operate. It provides excellent welding characteristics, smooth almost spatter free weld finish.

The wider arc, in comparison to solid wire, will reduce the risk of lack of fusion and is less sensitive against misalignment of edges and different gap widths.

Base materials

1.4306 X2CrNi19-11, AISI 304 L, 1.4301 X5CrNi18-10, AISI 304, 1.4308 GX6CrNi18-9
 1.4311 X2CrNi18-10, ASTM A320 Gr. B8C or D, AISI 304 LN, 1.4312 GX10CrNi18-8, ASTM A157 Gr. C9, AISI 302, 1.4541 X6CrNiTi18-10, AISI 321, 1.4546 X5CrNiNb18-10, AISI 321
 1.4550 X6CrNiNb18-10, AISI 347, 1.4552 GX5CrNiNb18-9

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

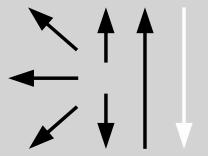
	C	Si	Mn	Cr	Ni
wt.-%	≤ 0.03	0.6	1.4	19.8	10.5

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	
	MPa	MPa	%	+20 °C	-196 °C
u	380 (≥ 320)	540 (≥ 520)	37 (≥ 35)	105	50 (≥ 32)

u untreated, as welded – shielding gas Argon + 2.5 % CO₂

Operating data

	Polarity:	Shielding gas:	∅ (mm)	amps A	voltage V
	DC (+)	M1	1.2	60 – 280	13 – 30
			1.6	100 – 370	13 – 32

Welding with conventional or pulsed power sources (preferably pushing technique torch position, angle appr. 80°). Recommended stick out 15 – 20 mm and length of arc 3 – 5 mm.

Positional weldability of metal cored wires is similar to solid wires (puls arc welding is recommended).

Approvals

TÜV (09987.), CE