

## Classifications

EN ISO 3581-A

AWS A5.4

E 19 9 L R 1 5

E308L-17

## Characteristics and typical fields of application

Rutile-basic electrode, core wire alloyed, stainless steel especially designed for vertical-down welding in the sheet metal fabrication.

Highly economical due to fast travel speeds. 50 % time saving is achieved compared to welding in vertical up position with same electrode diameter. The extremely low heat helps to reduce distortion and associated straightening work.

The product is resistant to intergranular corrosion up to service temperatures of +350 °C.

## Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 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; ASTM A157 Gr. C9; A320 Gr. B8C or D

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

	C	Si	Mn	Cr	Ni
wt.-%	0.02	0.7	0.7	19.8	10.5

## 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>470</b> (≥ 320)	<b>600</b> (≥ 520)	<b>36</b> (≥ 30)	<b>55</b>	≥ 32

u untreated, as welded

## Operating data

	Polarity: DC ( + )	Redrying if necessary: 120 – 200 °C, min. 2 h	Electrode identification: FOX EAS 2-VD 308L-17 E 19 9 L R	ø (mm)	L mm	Amps A
				2.5	300	75 – 85
3.2	300	105 – 115				

## Approvals

SEPROZ