

Classifications

EN ISO 3581-A	EN ISO 3581-B	AWS A5.4
E 19 9 L B 2 2	ES308L-15	E308L-15

Characteristics and typical fields of application

Basic stainless steel electrode. Due to the specific alloying concept and a controlled ferrite content of 3-8 FN (aimed 2-6 FN) the weld metal provides excellent impact toughness down to $-196\text{ }^{\circ}\text{C}$ along with later expansion values of $>0.38\text{ mm}$ which makes it suitable for LNG application as well. Designed to produce first class weld deposits with reliable CVN toughness values down to $-196\text{ }^{\circ}\text{C}$, 100% X-ray safety together with good root pass and positional welding characteristics, good gap bridging ability, easy weld pool and slag control as well as easy slag removal resulting in clean bead surfaces and minimum post weld cleaning. An excellent electrode for welding on site! Resistant to intergranular corrosion up to $+350\text{ }^{\circ}\text{C}$. Fully core wire alloyed and packed into hermetically sealed tins.

Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10,
1.4541 X6CrNiTi18-10,
AISI 304, 304L, 302, 321

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

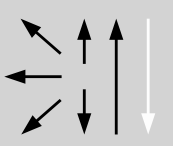
	C	Si	Mn	Cr	Ni
wt.-%	0.03	0.4	1.3	19.5	10.5

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		Lateral expansion
	MPa	MPa	%	$+20\text{ }^{\circ}\text{C}$	$-196\text{ }^{\circ}\text{C}$	$-196\text{ }^{\circ}\text{C}$
u	410 (≥ 320)	560 (≥ 520)	40 (≥ 30)	125	60 (≥ 34)	≥ 0.38

u untreated, as welded

Operating data

	Polarity: DC (+)	Electrode identification: FOX EAS 2 (LF) 308L-15 E 19 9 L B	\varnothing (mm)	L mm	Amps A
			2.5	300	50 – 80
			3.2	350	80 – 110
4.0	350	110 – 140			

Approvals

CE