

EN 12072:1999: W 19 9 L  
 AWS A5.9-93: ER308L  
 W.Nr.: 1.4316

# BÖHLER EAS 2-IG

GTAW rod, high-alloyed,  
 chemical resistant

## Description

GTAW rod of type W 19 9 L / ER308L suitable not only for standard welding jobs but also for cryogenic applications down to -269 °C.

Good welding and wetting characteristics of BÖHLER EAS 2-IG as well as corrosion resistance up to +350 °C is achieved.

## Typical Composition of Welding Rod

	C	Si	Mn	Cr	Ni
wt-%	0.02	0.5	1.7	20.0	10.0

## Mechanical Properties of All-weld Metal

(*)		u	
yield strength $R_e$ N/mm <sup>2</sup> :		450	(≥ 400)
tensile strength $R_m$ N/mm <sup>2</sup> :		620	(≥ 570)
elongation A ( $L_0 = 5d_0$ ) %:		38	(≥ 35)
impact work ISO-V KV J	+ 20 °C:	150	(≥ 100)
	- 269 °C:	75	(≥ 35)

(\*) u untreated, as-welded – shielding gas Argon

## Operating Data



shielding gases: **100 % Argon**

rod marking:

front:  **W 19 9 L**

back: **ER 308 L**

ø mm

1.6

2.0

2.4

3.0



## 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

## Approvals and Certificates

TÜV-D (0145.), DB (43.014.08), ÜZ (43.014/1), ÖBB, TÜV-A (97), CL (0655), DNV (308L),  
 GL (4550), UDT, SEPROZ

## Same Alloy Filler Metals

SMAW stick electrode:	FOX EAS 2	Metal cored wire:	EAS 2-MC
	FOX EAS 2-A	GMAW flux cored wire:	EAS 2-FD
GMAW solid wire:	FOX EAS 2-VD		EAS 2 PW-FD
	EAS 2-IG (Si)	SAW combination:	EAS 2-UP/BB 202