TL-86B8

AWS A5.5 E8016-B8 EN ISO 3580-B-E6216-9C1M JIS Z 3223 E5516-9CM

Characteristics and Applications:

TL-86B8 is a low hydrogen type electrode. The weld metal contains 9%Cr-1%Mo. High tensile strength, good toughness, and good heat resistance can be obtained. It is suitable for 9%Cr-1%Mo steel such as ASTM A387 Gr.9 for refineries, petrochemical and electric power plants, ASTM A199-T9, A335-P9 for pipes, A387-9 for drawing steel, A182-F9 for forging steel, etc..

Notes on usage:

- 1. Clean up the contaminations on the base metal and welding seam so as not to derogate the weld metal quality from particles.
- 2. Dry the electrodes at 250-350 $^\circ\!\mathrm{C}$ for 60 minutes before using.
- 3. Use back-step method to prevent arc starting from blowholes and hold for 3-5 seconds at every end-up.
- 4. Maintain short arc length. Moving range should be controlled within 3 times of the wire's dia when you are welding with weave method.
- 5. Do not exceed the range of recommended current. Over heat input might decrease the impact value.
- 6. Pre-heat the workpiece at 250~350 and proceed PWHT according to relevant specifications.

Typical chemical composition of weld metal (wt%):

С	Mn	Si	Р	S	Cr	Мо
0.07	0.78	0.50	0.018	0.01	9.1	1.0

Typical mechanical properties of weld metal:

Yield strength	Tensile strength	Elongation	PWHT
MPa(ksi)	MPa(ksi)	%	
600(87)	700(102)	23	740℃ x 1hr

Welding position:



Sizes and recommended current range (AC or DC <+>):

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350 🕁 450	450
Amps	F	90-120	100- 15 0	160-210
	V&OH	90-110	110-140	-

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