

# TLH-98B3P

AWS A5.5 E9018-B3 H4  
EN ISO 3580-B-E6218-2C1M H5

## Characteristics and Applications:

TLH-98B3P is an iron powder low hydrogen type electrode with extremely low impurity for low alloy heat resistance steel. The weld metal contains 2.25%Cr-1%Mo that makes the electrodes more suitable for the welding of piping steels (STPA24, A335-P22), boilers (STBA24 A199T22 A213T22 A200T22), heat exchanger pipes (A182-F22, A336-F22) which the service temperature is at 550 . The product provides good creep rupture strength at high temperature.

## 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 350-400 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.

## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Mo
0.1	0.70	0.18	0.010	0.010	2.22	1.0

## Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20 )	PWHT
660(96)	750(109)	22	70(52)	690 x1hr

## 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	90-130	140-190	190-240
	V&OH	80-110	130-160	-

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