

# TL-86B8

JIS Z 3223 DT2616  
AWS A5.5 E8016-B8  
EN1599 E CrMo 9 B 1 2

## 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°C for 60 minutes before use.
3. Use back-step method and hold for 3-5 seconds at every end-up to prevent arc starting from blowholes.
4. Maintaining short arc length as possible is highly recommended. While welding with weave method, moving range should be controlled within 3 times of the wire's dia.
5. When the heat input is excessive, the impact value tends to be reduced. Therefore, select proper heat input depending on the required impact value.
6. Pre-heat the workpiece at 250~350°C and proceed PWHT according to relevant specifications.

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

C	Mn	Si	P	S	Cr	Mo
0.075	0.70	0.50	0.020	0.010	9.50	1.00

## Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	PWHT
610	720	22	740°C x 1hr

## Welding position



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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	80-130	100-160	160-210
	V&OH	70-110	80-130	-

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