

# TL-96B3

JIS Z 3223 DT2416  
AWS A5.5 E9016-B3  
EN1599 E CrMo2 B 1 2

## Characteristics and Applications:

TL-96B3 is a low hydrogen electrode 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, A199-T22, A 200-T22 ), heat exchanger pipes (A213-T22), casting steels (A217-WC9) and forging steels (A182-F22, A336-F22) which being used at 550°C.

## Notes on Usage:

1. Dry the electrodes at 350-400°C for 60 minutes before use.
2. Take the back-step method to start arc.
3. Keep arc as short as possible.
4. Preheat temperature in accordance with spec..

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

C	Mn	Si	P	S	Cr	Mo
0.07	0.65	0.50	0.015	0.010	2.20	1.00

## Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	PWHT
600	715	23	690°Cx1hr

## 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	90-140	140-190	190-240
	V&OH	80-120	120-160	-

\* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Tien Tai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by Tien Tai Electrode Co., Ltd.