TL-96B9

AWS A5.5 E9016-B9 EN ISO 3580-B-E6216-9C1MV JIS Z 3223 E6216-9C1MV

Characteristics and Applications:

TL-96B9 is a low hydrogen type electrode. The weld metal contains 9%Cr-1%Mo and some little Nb, V to improve the creep problem at prolonged high temperature. With the characters of stable arc, little spatter, complete slag covering, it is suitable for welding the steel such a ASTM A213-T91, A335 P91, A387 Gr.91, A182 F91.

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.
- 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.

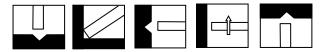
Typical chemical composition of weld metal (wt%):

С	Mn	Si	Р	S	Cr	Мо	Nb	V	N
0.085	0.7	0.25	0.01	0.01	10.3	1.0	0.05	0.20	0.03

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)			PWHT	
580(84)	712(103)	24	760°C x 2hrs	

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	90-130	140-	-180	160-220	

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