

TL 88

International Standards:

AWS SFA 5.5 : E 8018-B2
 JIS Z 3223 : DT2318
 DIN 8575 : E CrMo1 B 2 6
 DIN EN 1599 : E CrMo1 B 3 2

Characteristics and Applications :

TL 88 is an iron powder low hydrogen electrode. The weld metal contains 1,25% Cr - 0,5% Mo that makes electrodes more efficient at 550°C. With the characters of stable arc, little spatter, complete slag covering, it's suitable for the welding of steel tube for heat transfer of boiler (STPA22,23, A335-P11, P12, A199T11, A200T11, A213T11-12), drawing steel (A387Gr11-12), cast iron (A217-WC6), and forging steels (A182-F11, F12).

Notes on Usage :

1. Clean up the contaminations on the base metal
2. Dry the electrodes at 200°C for 2 hours before use
3. Use back-step method & hold for 3-5 seconds at every end-up to prevent arc starting from blowholes
4. Maintain arc length as short as possible is highly recommended
5. Preheat the workpiece at 150 - 300°C and proceed PWHT at 620 - 700°C

Typical Chemical Analysis of Deposited Metal (%) :

C	Mn	Si	P	S	Cr	Mo
0,069	0,58	0,31	0,024	0,005	1,32	0,65

Typical Mechanical Properties of Deposited Metal :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Post Weld Heat Treatment (PWHT)
643	732	27	690°C / 1 hour

Size & Recommended Current Range (AC or DC) :

Size (mm)		3,2 x 350	4,0 x 400	5,0 x 400
Amperages (Amp)	F	90 - 140	140 - 190	190 - 240
	V&OH	80 - 120	120 - 160	-
Weight / pack (kgs)		5	5	5
Weight / carton (kgs)		20	20	20

Welding Position :

Attention!
 Redrying: 200°C / 2 hrs



SYMBOL OF QUALITY

Manufactured by:

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