



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 186 – Alloy containing finely divided chromium carbides which are highly resistant to abrasive wear

FEATURES & APPLICATIONS

Especially suited for metal to metal wear applications involving steel, manganese steel and cast iron.

Wear facing electrode for impact and moderate abrasion

- Excellent welding characteristics
- Deposits are very crack resistant
- Multiple layers are easily applied for thick build-ups

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Martensite with some dispersed carbides.

Flux Colour: Grey

C	Mn	Si	S	P	Cr	Fr
.65	.5	1.2	.04	.03	9.3	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal
Hardness

Maximum Value Up To
Vickers 650
Rockwell C58-60

PROLINE
professional welding supplies

Ph: 0800 699 353
sales@prolinewelding.com



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+/-) or AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	80	110	140
Maximum Amperage	120	160	180

Welding Techniques: No preheat required. Remove all loose and foreign matter. Deposit stringer or weave beads using a short arc length.

Welding Positions: Flat, Horizontal

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time Of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
1/8 (3.25)	14" (350)	1.1oz (31g)	14 (30)	23 (50)	120	130%
5/32 (4.0)	14" (350)	2.7oz (76g)	6 (14)	17 (37)	175	130%
3/16 (5.0)	14" (350)	4oz (112g)	4 (9)	13 (29)	250	130%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes/lb	8	6	5
Electrodes/kg	18	13	11