



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 501 – High resistant electrode for underlay of hard surfacing

FEATURES & APPLICATIONS

For welding and cladding stabilised and unstabilised stainless steels to themselves and to carbon steels.

Fully synthetic 316 stainless high performance joining and cladding electrode

- A true non-overheating 316 stainless steel electrode
- Very high speed weld deposition compares with MIG welding
- Self releasing slag – eye appealing welds

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with 7-9% ferrite. Typical ferrite number 6

Flux Colour: Grey

Mo	Ni	C	Si	P	Mn	S	Cr	Cu	Cb
2.8	12.6	.06	.90	.02	.91	.01	17.91	.11	.05

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Impact Energy
Hardness

Maximum Value Up To

107,000 PSI (750 MPa)
75,000 PSI (520 MPa)
36%
40J: -157°F (-105°C)
Brinell 190, Rockwell B92



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	65	90	145
Maximum Amperage	75	105	145	215

Welding Techniques: Weld with the electrode tilted slightly using a short arc or the drag technique. This high recovery electrode allows you to use smaller than normal electrode diameters.

Welding Positions: Flat, Horizontal, Vertical up

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
1/16 (1.6)	10" (250)	.35oz (10g)	46 (102)	36 (79)	65	170%
3/32 (2.5)	14" (350)	.7oz (20g)	23 (50)	25 (56)	85	170%
1/8 (3.25)	14" (350)	1.14oz (32g)	14 (30)	17 (38)	120	170%
5/32 (4.0)	14" (350)	1.78oz (50g)	9 (20)	10 (23)	180	170%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	12" (300)	12" (300)	14" (350)	14" (350)
Electrodes/lb	67	42	28	13	9
Electrodes/kg	147	92	62	29	20

PROLINE
professional welding supplies

Ph: 0800 699 353
sales@prolinewelding.com