



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 507T – High tensile TIG rod for welding all types of low and high carbon and alloyed steels

FEATURES & APPLICATIONS

Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for aluminium and copper alloys. It is also recommended for repairing worn parts and as an underlay for hardfacing.

The ultimate electrode for welding all types of steels, without any danger of cracking or breakage. The engineered deposit chemistry gives the 507T the perfect ratio of metallic to offer crack resistance far superior to any other brand.

- Also available in MMA arc electrodes STRATA 507U

- **ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)**

Approximate Chemical Composition of Weld Metal Typical values acc. EN10204 '2.2'

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu	V	Al	Ag
0.1	0.42	1.80	0.02	0.001	30	10	0.11		0.06			
Ti	B	Co	W	As	Sn	Sb	Pb	Mg	Zn	Fe		N
										Bal.		

*Special specification exceeding chemistry for extreme crack resistance

Microstructure: A duplex austenite/delta ferrite structure with a Shaeffler ferrite value below 40%.

Special Proprietary Non-Conforming Chemistry

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength as Welded	128,000 PSI (880 MPa)
Work Hardened	186,000 PSI (1280 MPa)
Yield Strength	90,000 PSI (630 MPa)
Elongation	32%,
Impact Energy	50J: 68°F (20°C)
Hardness	Brinell 320 Rockwell B97

WELDING CURRENT & INSTRUCTIONS

The welding parameters for TIG welding are largely dependent upon the plate thickness and welding position. Straight polarity and argon or helium shielding gas should be used.

PROLINE
professional welding supplies

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