



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 520 – Very easy to use special stainless steel electrode

FEATURES & APPLICATIONS

For molybdenum bearing stainless steels with 1.5 to 3.0% Mo. Primarily used for resistance to pitting, many acids and general corrosion.

Maintenance quality smooth running molybdenum bearing 316L-16 electrode

- Excellent all position capabilities
- Extra low carbon content to resist pitting
- Suitable for titanium and niobium stabilized versions of 316L stainless

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

Flux Colour: White-Grey

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.018	.9	.75	.01	.02	19	12	2.65	.1	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength as Welded
Yield Strength
Elongation
Impact Energy
Hardness

Maximum Value Up To

80,000 PSI (550 MPa)
56,000 PSI (390 MPa)
42%
40J: -157°F (-105°C)
Brinell 209, Rockwell B96

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)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	25	30	55	75	90
Maximum Amperage	35	50	75	110	140

Welding Techniques: Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer bead rather than a weave technique.

Welding Positions: Flat, Horizontal, Vertical up, Overhead

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)	.13oz (3.6g)	125 (275)	55 (121)	30	100%
5/64 (2.0)	12" (300)	.14oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5)	12" (300)	.3oz (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1oz (29g)	15 (33)	18 (40)	120	100%

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	2	29	20