



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 581 – Super, easy to use electrode for low alloyed steels

FEATURES & APPLICATIONS

All position welding of fine grained unalloyed structural and construction grade steels with a carbon content of up to .4%.

New technology – Very unique “Double Coated” low hydrogen electrode excels at AC welding

- Unique “Double” flux coating separates those flux constituents which impair arc stability to the outside of the flux coating
- The only “Low Hydrogen” electrode that can easily be used on low open circuit voltage AC farm type welders
- The unusually stable arc makes this electrode ideally suited for root passes and positional welding

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the stress-relieved condition the microstructure consists of acicular ferrite with some tempered bainite.

Flux Colour: White/Grey

C	Mn	Cr	Si	Mo	S	V	P	Ni	Fe
.08	1.12	.20	.60	.30	.011	.08	.010	.30	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Impact Energy

Maximum Value Up To

87,000 PSI (630 MPa)

72,000 PSI (520 MPa)

31%

12J: -20°C

PROLINE
professional welding supplies

Ph: 0800 699 353
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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3.16 (5.0)
Minimum Amperage	60	90	140	200
Maximum Amperage	90	135	190	260

Welding Techniques: Clean areas to be joined. Initiate arc and use conventional "stringer weld" technique. Electrode can be dragged.

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
3/32 (2.5)	12" (300)	.42oz (12g)	38 (83)	38 (84)	75	118%
1/8 (3.25)	14" (350)	.59oz (17g)	27 (60)	21 (47)	115	118%
5/32 (4.0)	18" (450)	1.4oz (39g)	12 (26)	18 (39)	165	118%
3/16 (5.0)	18" (450)	2.3oz (64g)	7 (16)	13 (28)	230	118%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	18" (450)	18" (450)
Electrodes/lb	21	12	6	5
Electrodes/kg	46	26	14	10