



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 636 – Aluminium electrode

FEATURES & APPLICATIONS

For arc welding aluminium that has been alloyed with copper, silicon and magnesium. Also excellent for joining dissimilar grades of aluminium.

5% Silicon aluminium arc welding electrode with exclusive self lifting slag. Other aluminium grades such as Al99, Al Mn etc are also available.

- Unique self lifting slag
- The only aluminium electrode manufactured in a “Low Temperature” 5/64 (2.0mm) x 10” (250mm) size
- Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance
- Can be manufactured in a variety of custom colours
- Available in hermetically sealed PURE ALUMINIUM pull ring cans or vacuum packed foil bags for extended shelf life
- Also available in TIG form as item code 6009, in MIG form as item code 7090 and as a bare torch brazing alloy as item code 2190

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: White or Custom Colours

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
5.25	.23	.8	.04	.04	.08	.20	.0008	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Maximum Value Up To

32,000 PSI (230 MPa)

20,000 PSI (150 MPa)

18%



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	20	50	70	110
Maximum Amperage	60	80	120	150

Welding Techniques: Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

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
5/64 (2.0)	10" (250)	.08oz (2.6g)	184 (404)	176 (337)	40	90%
3/32 (2.5)	14" (350)	.14oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.25)	14" (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%
5/32 (4.0)	14" (350)	.33oz (9.g)	48 (107)	47 (103)	135	90%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	14" (350)	14" (350)	14" (350)
Electrodes/lb	80	49	33	23
Electrodes/kg	176	108	73	51

PROLINE
professional welding supplies

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