



# STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

**STRATA 82F – Tough machineable alloy for build up and overlay applications.**

## FEATURES & APPLICATIONS

High strength joining of steels using both the thin flow and bead form techniques.

Ultra high purity nickel silver alloy featuring “Safe Vue” moisture sealed flux coating

- Unique “Safe Vue” flux coating eliminates harsh chemical odours and the bright orange visibility blocking glare of conventional sodium type flux coatings
- Slick, smooth moisture sealed flux has triple the shelf life of similar products
- Flux cleansing action is exceptional on dirty steels and cast irons

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: 3182 Red } Stocked  
3186 White } at all  
3189 Bare } times

\*All other colours can be special ordered in bulk quantities

Al	Sn	Si	Ni	Pb	P	Cu	Zn
.01	.002	.21	10.5	.02	.15	48.5	bal

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	102,000 PSI (700 MPa)
Yield Strength	90,000 PSI (630 MPa)
Elongation	28%
Hardness	Rockwell B 96 Brinell 210
Work Hardness	Rockwell C 25 Brinell 265

**Recommended Torch Setting:** Neutral Flame

**PROLINE**  
*professional welding supplies*

Ph: 0800 699 353  
sales@prolinewelding.com



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## Temperature Ranges:

<b>Working Temperature:</b>	1595°F (878°C)
<b>Melting Range:</b>	1583° - 1640°F (870°C - 895°C)

## BRAZING INSTRUCTIONS

**Welding Techniques:** Ensure that parts to be joined are clean. Pre-heat general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

## Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Rods per lb (kg) of Weldmetal
1/16 (1.6)	18" (450)	.3oz (8.6g)	53 (117)
3/32 (2.5)	18" (450)	.6oz (17.5g)	27 (59)
1/8 (3.25)	18" (450)	1.1oz (31g)	15 (33)
3/16 (5.0)	18" (450)	2.4oz (67g)	7 (15)

## APPROXIMATE ROD PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	3/16 (5.0)
Length (mm)	18" (450)	18" (450)	18" (450)	18" (450)
Rods/lb	47	23	13	6
Rods/kg	103	51	29	13