



# STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

**STRATA 885 – For difficult position cast iron repairs with special no side arc characteristics**

## FEATURES & APPLICATIONS

Very soft machineable welds on all weldable cast irons. Especially suited for welding in deep recesses or close quarters due to the non-conductive flux coating.

Soft, very machineable high nickel cast iron electrode featuring a totally non-conductive flux coating.

Flux coating does not side arc even after being heated.

- Unusually strong arc drive penetrates oil and grease easily
- Excellent for vertical up welding
- Can be ordered in a red/brown flux colour as product code 1840
- Also available in TIG form as product code 6004

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Austenitic nickel with finely distributed graphite flakes

**Flux Colour:** Black or Red/Brown (code 1840)

C	Mn	Si	S	P	Cu	Fe	Al	Misc	Ni
.136	.14	.08	.006	.006	.019	1.71	.089	1 max	Bal

## TYPICAL MECHANICAL PROPERTIES

### Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Hardness

### Maximum Value Up To

55,000 PSI (380 MPa)

38,000 PSI (270 MPa)

30%

Rockwell B 82-84, Brinell 155, Vickers 14

**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)
Minimum Amperage	70	80	130
Maximum Amperage	90	120	160

**Welding Techniques:** Maintain a close arc gap and move rapidly in the direction of travel. Slag can be welded over without removal.

**Welding Positions:** Flat, Vertical up, Vertical down, Horizontal, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	12" (300)	.64oz (18g)	22 (48)	44 (97)	80
1/8 (3.25)	14" (350)	.77oz (21g)	21 (47)	21 (46)	110
5/32 (4.0)	14" (350)	1.07oz (31g)	15 (32)	20 (45)	135

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes/lb	22	13	9
Electrodes/kg	48	29	20