



STRATA
SUPERIOR WELDING PRODUCTS



STRATA 636

ALUMINIUM ARC WELING ELECTRODES WITH EXCLUSIVE SELF-LIFTING SLAG

AWS: A5.3 E4043

USAGE: For ARC Welding aluminium, alloyed with copper, silicon, and magnesium. Excellent for joining dissimilar grades of aluminium. 5% Silicon for improved weldability.

- Unique self lifting slag
- Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: White

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
5.25	.01	.17	.002	.002	.001	.01	.0001	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	32,000 PSI (230 MPa)
Yield Strength	20,000 PSI (150 MPa)
Elongation	18%



STRATA 636 ALUMINIUM ELECTRODES

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.2)
Minimum Amperage	50	65
Maximum Amperage	80	120

Welding Techniques: Clean the weld area thoroughly. Base metals heavier than 3mm (1/8") should be beveled at a 75° angle. Pre-heat up to 200°C. Hold electrode almost vertical to work piece and strike arc by lightly drawing electrode on work piece or with copper starting block. Maintain short arc and remove slag between passes. Back whip any craters. Allow to cool slowly. Chip slag before quenching.

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
3/32 (2.5)	14" (350)	.14oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.2)	14" (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.2)
Length (mm)	14" (350)	14" (350)
Electrodes/lb	49	33
Electrodes/kg	108	73

ORDERING INFO

Diameter	Pack Size	Product Code
2.5mm	1KG	#202324
3.2mm	1KG	#202328

NOTE: There are 4x 1KG packs per carton

