



STRATA
SUPERIOR WELDING PRODUCTS



STRATA 507U

SUPER STRENGTH ULTRA-LOW INPUT ELECTRODE

USAGE: Exceptional strength and crack resistance. Ideal for repairing tools, dies, spring steel and dissimilar metal combinations.

- Strata 507U is a lime-titania type electrode that gives 29% Cr - 9%Ni
- Excellent crack resistibility due to high ferrite structure of weld metal

Application

- Welding of dissimilar metals, such as stainless steel to mild steel and low alloy steel
- Welding of stainless clad steel
- Under-laying of hard surfacing

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Si	Mn	Ni	Cr	Mo	Cu
0.09	0.85	0.93	9.30	29.40	0.07	0.10

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	120,000 PSI (830 MPa)
Elongation	25%

AWS: A5.4 E312-17



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC, DC (+)

Diameter (mm)	Length (mm)	Current Amp Flat	Current Amp Vertical & Overhead
2.5	300	50 - 80	45 - 75
3.2	350	70 - 110	65 - 105
4.0	350	100 - 150	95 - 140

Welding Positions: All positions

Remarks

- Choose the welding current as low as possible to prevent cracking of plate
- It is necessary to preheat the plate at 200°C and over in the case of welding of special steel, such as high alloy tool steels

ORDERING INFO

Diameter	Pack Size	Product Code
2.5mm	1KG	#202258
3.2mm	1KG	#202262
4.0mm	1KG	#202266

NOTE: 10 x 1KG packs per carton.