STRATA
SUPERIOR WELDING PRODUCTS

STRATA 885

PURE NICKEL ELECTRODE WITH NON-CONDUCTIVE COATING

USAGE: Suitable for all weldable cast irons. Deposits are soft and machinable. The non-conductive coating makes ST885 magnificent for welds in difficult positions or deep recesses.

- ST885 is a pure nickel electrode with non-conductive coating Ignition does not occur upon contact between coating and workpiece Good wetting on the base material due to the electrode melting slowly
- Weld deposit is mechanically machinable

Application

- Hot and cold welding of gray cast iron
- Joining and surfacing of machines
- Frames
- Housing of gray cast iron, bearing blocks, etc.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Si	Mn	Ni	Fe
0.43	0.32	0.41	Bal.	1.00

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	49,000 PSI (340 MPa)
Elongation	15%
Hardness HV (HRC)	140 - 160 (75 - 80)

AWS: A5.15 ENiC1

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WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC, DC (+)

Diameter (mm)	Length (mm)	Current Amp
2.5	350	70 - 90
3.2	350	80 - 120
4.0	350	120 - 150

Welding Positions: Flat, fillet, vertical UP, horizontal, overhead N/A

Remarks

- Clean base metal before welding
- Keep bead length less than 50mm to disperse welding heat. Adopt back step, stepping stone, or symmetry methods by turns
- Hot peen in every pass
- It is not necessary to preheat and postheat in general but satisfactory results can be obtained by preheating at 100-200ºC in accordance with the kind, shape, and size of base metal

ORDERING INFO

Diameter	Pack Size	Product Code
2.5mm	1KG	#202352
3.2mm	1KG	#202356
4.0mm	1KG	Special Order

NOTE: 10 x 1KG packs per carton.