STRATA
SUPERIOR WELDING PRODUCTS

STRATA 507

PREMIUM BUFFER LAYER & DISSIMILAR METAL ELECTRODE

USAGE: Ideal for joining dissimilar metals & welding CR-MO or carbon steel. Perfect for build-up or buffer layers prior to hard-facing.

- ST507 is a lime-titania type electrode designed for all-position welding,
- Excellent resistance against diluted sulfuric acid
- Weld metal provides good corrosion resistibility and heat resistibility in the as-welded condition
- Can be used for welding of extra-low carbon stainless steel that contains Mo and for under laying of mother plates with considerably high carbon content

Application

- Build up welding of Cr-Mo steel or carbon steel
- Welding of AISI 316 or AISI 316L to carbon steel
- Clad steel side welding to AISI 316 or AISI 316L

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Si	Mn	Ni	Cr	Mo
0.03	0.65	1.10	12.84	23.71	2.31

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	88,000 PSI (606 MPa)
Elongation	41%

AWS: A5.4 E309MoL-16

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WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC, DC(+), 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

- Keep the arc as short as possible
- Select appropriate welding current
- Weaving width should be within 2.5x of electrode diameter
- When the electrodes have absorbed moisture, dry them at 250-300°C for 60-90 minutes before use

ORDERING INFO

Diameter	Pack Size	Product Code
2.5mm	1KG	#39544
3.2mm	1KG	#39545
4.0mm	1KG	Special Order

NOTE: 10 x 1kg pack per carton.