



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 171 – Crusher type electrode

FEATURES & APPLICATIONS

General hardfacing where some impact is combined with abrasion.

Economical hardfacing electrode for abrasion and moderate impact

- The best hardfacing electrode for low open circuit voltage AC welding machines
- Spray transfer allows for smooth, uniform overlays
- Hardness of RC 56-58 allows for good abrasion resistance along with moderate impact resistance
- Also available as a special tubular MIG wire as Product Code 7260

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-deposited condition, the microstructure consists of martensite and some carbides.

Flux Colour: Grey

C	Mn	Si	P	S	Cr	I	Mo	Fe
.56	.95	.43	.018	.014	5.7	.03	.63	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Hardness

Wear Co-efficient

Maximum Value Up To

Rockwell C 56-58

2.8%



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	150	200
Maximum Amperage	130	190	260

Welding Techniques: Weld deposits are best applied using a weave technique. Full undiluted hardness is usually achieved after 2 to 3 passes.

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
1/8 (3.25)	14" (350)	.9oz (26g)	18 (39)	23 (50)	110	130%
5/32 (4.0)	14" (350)	2.5oz (71g)	6 (14)	17 (37)	165	130%
3/16 (4.0)	14" (350)	3.7oz (105g)	4 (9)	13 (29)	230	130%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes/lb	12	8	6
Electrodes/kg	26	18	13