



# STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

## STRATA 554 – Extreme electrode for welding under extreme conditions

### FEATURES & APPLICATIONS

Ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanised, painted, rusted, or otherwise contaminated in service. Misaligned parts of difficult to access areas are also easily remedied with this electrode.

Adverse conditions mild steel electrode. Excels on rusty, greasy, poor fitting joints in all positions.

- Can weld through 1/2" (12mm) of surface contamination without porosity
- Can bridge gaps as wide as 3/8" (9mm)
- Electrode can be bent without flux chipping
- Slag can be welded over without removal

### ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: Dark Brown

C	Mo	Mn	Cr	Si	Ni	V	Fe
.09	.30	.59	.20	1.00	.30	.06	Bal

### TYPICAL MECHANICAL PROPERTIES

#### Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Impact Energy

#### Maximum Value Up To

88,000 PSI (630 MPa)

80,000 PSI (570 MPa)

28%

70J: -4°F (-20°C)



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## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+), Straight (-) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	25	35	50	75
Maximum Amperage	75	125	160	200

**Welding Techniques:** Weld with a short-medium arc length at low amperage. When surface preparation is impractical, use a medium-long arc and favour high amperages. Multi-pass welds can be made without intermittent slag removal. Use any welding technique from stringer bead to wide weave.

**Welding Positions:** Flat, Vertical up, Vertical down, Horizontal, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	14" (350)	.27oz (7g)	45 (100)	37 (81)	50
1/8 (3.25)	14" (350)	.56oz (15g)	25 (56)	25 (56)	80
5/32 (4.0)	14" (350)	.9oz (25g)	17 (38)	20 (45)	105
3/16 (5.0)	14" (350)	1.35oz (38g)	12 (26)	15 (34)	140

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)	14" (350)
Electrodes/lb	31	18	11	8
Electrodes/kg	68	40	24	18