



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 82F – Tough machineable alloy for build up and overlay applications.

FEATURES & APPLICATIONS

High strength joining of steels using both the thin flow and bead form techniques.

Ultra high purity nickel silver alloy featuring “Safe Vue” moisture sealed flux coating

- Unique “Safe Vue” flux coating eliminates harsh chemical odours and the bright orange visibility blocking glare of conventional sodium type flux coatings
- Slick, smooth moisture sealed flux has triple the shelf life of similar products
- Flux cleansing action is exceptional on dirty steels and cast irons

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour:	3182	Red	} Stocked at all times
	3186	White	
	3189	Bare	

*All other colours can be special ordered in bulk quantities

Al	Sn	Si	Ni	Pb	P	Cu	Zn
.01	.002	.21	10.5	.02	.15	48.5	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up To
Tensile Strength	102,000 PSI (700 MPa)
Yield Strength	90,000 PSI (630 MPa)
Elongation	28%
Hardness	Rockwell B 96 Brinell 210
Work Hardness	Rockwell C 25 Brinell 265

Recommended Torch Setting: Neutral Flame



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Temperature Ranges:

Working Temperature:	1595°F (878°C)
Melting Range:	1583° - 1640°F (870°C - 895°C)

BRAZING INSTRUCTIONS

Welding Techniques: Ensure that parts to be joined are clean. Pre-heat general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Rods per lb (kg) of Weldmetal
1/16 (1.6)	18" (450)	.3oz (8.6g)	53 (117)
3/32 (2.5)	18" (450)	.6oz (17.5g)	27 (59)
1/8 (3.25)	18" (450)	1.1oz (31g)	15 (33)
3/16 (5.0)	18" (450)	2.4oz (67g)	7 (15)

APPROXIMATE ROD PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	3/16 (5.0)
Length (mm)	18" (450)	18" (450)	18" (450)	18" (450)
Rods/lb	47	23	13	6
Rods/kg	103	51	29	13