



STRATA INTERNATIONAL LTD.

SUPERIOR PRODUCTS FOR MAINTENANCE AND REPAIR

STRATA 845 – Special non-machineable, cast iron electrode for dirty heat-affected cast iron

FEATURES & APPLICATIONS

For non-machineable welds on machine bases, furnace grates, exhaust manifolds etc.

Nickel free cast iron problem solver, seals in porosity generating contaminants prior to finish welding with nickels.

- Easily clads heat oxidised and oil impregnated castings
- Perfect colour match to cast iron
- Non-conductive flux coating

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Colour: Black

C	Mn	Si	S	P	Fe
.12	.58	.02	.03	.03	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Hardness

Maximum Value Up To

62,000 PSI (440 MPa)

50,000 PSI (360 MPa)

20%

Brinell 380, Rockwell C39



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WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

Welding Techniques: Use stringer or moderate weave technique. When cladding, cover the entire base surface prior to finish welding.

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

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
3/32 (2.5)	14" (350)	.30oz (8g)	53 (117)	36 (79)	70	100%
1/8 (3.25)	14" (350)	.62oz (17g)	26 (57)	25 (55)	100	100%
5/32 (4.0)	14" (350)	1oz (28g)	16 (35)	20 (44)	135	100%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes/lb	26	14	10
Electrodes/kg	57	31	22