



JS-100 JET-SPRAY TORCH

for the application of powered metal
for build-up or hardfacing

QTY	DESCRIPTION
1	Torch Handle
1	Powder Hopper Assy
1	Goose Neck Elbow Assy
3	Tips
1	1 lb. Bottle Build-up #22 Powder (63TG)
1	1 lb. Bottle Wear Prevention - 600 Powder (85TG)
1	"How-to" Video



PROCESS

The manual powder torch enables the operator to apply build-up or hardfacing alloys to extend the life of common tools. Through the simple application of general oxyacetylene surfacing practices, smooth dense coatings can be achieved. Powder applications and fusion are incorporated in one easy operation. The powder flow rate and movement of the torch control deposit thickness.



Designed to mate with your existing oxy-acetylene source equipment, the manual powder torch comes complete with torch handle, elbow assembly, 3 different size heating tips, a 1 lb. bottle of each of the 2 most commonly used build-up and hardfacing powders and a "how-to" video. Additional powders are available for more demanding applications where greater surface hardness is required. Choose a Rockwell hardness from RC 22 to RC 60.

The simple, maintenance free design makes the manual powder torch easy to set up even easier to use. Operation is so easy, even a novice welder can repair broken cast iron parts, apply wear resistant coatings to thin parts, or replace metal worn by erosion or abrasion. All with superior metallurgical bonds.

TORCH GRADE SPRAY POWDER SELECTION

Stoody's spray powders are specifically designed for enhanced wetting characteristics in hand-held torch applications. These hardfacing powders cover a broad range of wear resistance needs.

STOODY 60 T.G. A nickel-base alloy with outstanding resistance to abrasion, corrosion and high heat; impact resistance is good. Low coefficient of friction. Use for pump components, shaft sleeves, thrust collars, guides, bushings. Finish by grinding.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
.7	4.4	15.0	3.1	-	4.2	Bal.	59 Rc

STOODY 63 T.G. A nickel-base alloy with high ductility and workability. Deposits can be hand ground. Used primarily in the glass industry to protect mold rebuilding against abrasion, heat and corrosion.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
.02	2.8	-	1.6	-	.4	Bal.	19 Rc

STOODY 64 T.G. A nickel-base alloy recommended for application to parts requiring precise finish machining. Can also be ground. Deposits provide excellent corrosion and heat resistance; very good impact resistance. Use on pump parts, shafts, valves, dies.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
0.3	3.5	8.8	1.8	-	2.8	Bal.	39 Rc

STOODY 65 T.G. Has greater ductility than Stoody 60. Deposits can be machined with carbide tools or ground. Nickel-base alloy for pump parts, dies, extrusion screws, wear rings.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
.45	4.0	11.9	2.1	-	3.5	Bal.	51 Rc

STOODY 85 T.G. A nickel-base tungsten carbide powder. Microstructures exhibit dense deposits of undissolved tungsten carbides embedded in high strength matrix. This material provides excellent wear resistance and is ideal for such applications as tillage tools, small mill hammers, bits and augers, etc. Stoody 85 T.G. is not recommended for metal-to-metal mating parts.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
2.2	2.5	8.3	1.7	43.0	2.6	Bal.	64 Rc Matrix

STOODY 86 T.G. A nickel-base tungsten carbide powder. Microstructures exhibit dense deposits of undissolved tungsten carbides embedded in high strength matrix. Similar to 85 T.G. but has an increased ratio of tungsten to provide even greater wear resistance.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
2.6	1.9	6.0	1.2	57.0	2.0	Bal.	64 Rc Matrix

STOODY 87 T.G. A nickel-base tungsten carbide powder. Microstructures exhibit dense deposits of undissolved tungsten carbides embedded in high strength matrix. Similar to 85 T.G. and 86 T.G. but has a maximum amount of tungsten to provide the ultimate in wear resistance. Not recommended for metal-to-metal wear.

C	Si	Cr	B	WC	Fe	Ni	NOMINAL HARDNESS
2.8	1.7	5.3	1.1	61.7	1.8	Bal.	64 Rc Matrix

- 1. SURFACE PREPARATION:** The surface to be sprayed should be degreased and free of oxides and other contaminants. Rough grit blast or grind to clean white metal for best results.
- 2. PREHEAT & PRESPRAY:** Evenly preheat part to 600 to 800°F (Steel at this temperature turns from blue back to white metal when the flame is wiped across the surface). Prespray a thin layer of powder over the entire surface to be coated.
- 3. FUSION:** Starting at one end of the presprayed part, continue to preheat until surface temperature is approximately 1900°F or until the presprayed powder becomes molten, at which time it is ready for complete fusion. Begin powder spray to evenly coat the part. If a thicker coating is required, evenly spray additional layer of powder to the desired thickness.
- 4. STANDARD MESH SIZE:** All of the powders are 140 x 400 except for 65 TG which is 140 x 325.

**U.S. Customer Care: 800-426-1888 / FAX 800-535-0557 • Canada Customer Care: 905-827-4515 / FAX 800-588-1714
International Customer Care: 905-827-9777 / FAX 905-827-9797 • www.stoody.com**



A Global Cutting & Welding Market Leader™

THE AMERICAS

Denton, TX USA
U.S. Customer Care
Ph: (1) 800-426-1888
Fax: (1) 800-535-0557

Miami, FL USA
Sales Office, Latin America
Ph: (1) 954-727-8371
Fax: (1) 954-727-8376

Oakville, Ontario, Canada
Canada Customer Care
Ph: (1) 905-827-4515
Fax: (1) 800-588-1714
International Customer Care
Ph: (1) 905-827-9777
Fax: (1) 905-827-9797

EUROPE

Chorley, United Kingdom
Customer Care
Ph: (44) 1257-261755
Fax: (44) 1257-224800

Milan, Italy
Customer Care
Ph: (39) 0236546801
Fax: (39) 0236546840

ASIA/PACIFIC

Cikarang, Indonesia
Customer Care
Ph: 62 21+ 8983-0011 / 0012
Fax: 62 21+ 893-6067

Osaka, Japan
Sales Office
Ph: 816-4809-8411
Fax: 816-4809-8412

Melbourne, Australia
Australia Customer Care
Ph: 1300-654-674
Fax: 613+ 9474-7391
International
Ph: 613+ 9474-7508
Fax: 613+ 9474-7488

Rawang, Malaysia
Customer Care
Ph: 603+ 6092-2988
Fax: 603+ 6092-1085

Shanghai, China
Sales Office
Ph: 86 21+ 6280-1273
Fax: 86 21+ 3226-0955

Singapore
Sales Office
Ph: 65+ 6832-8066
Fax: 65+ 6763-5812