

**DESCRIPTION**

Stoody 21 is a tubular electrode with good impact and abrasion characteristics. Deposits are not machinable or forgeable. Stoody 21 bonds well with carbon, low alloy, and manganese steels. Deposits are slightly magnetic on carbon and low alloy steels, but no on manganese steels, and will develop cross checks.

**TYPICAL DEPOSIT CHARACTERISTICS**

|                       |             |
|-----------------------|-------------|
| Abrasion Resistance   | Good        |
| Impact Resistance     | Moderate    |
| Hardness              |             |
| On Carbon Steel       | HRC 52 – 56 |
| On Manganese Steel    | HRC 46 – 50 |
| Magnetic              |             |
| On Carbon Steel       | Slightly    |
| On Manganese Steel    | No          |
| Surface Cross Checks  | Yes         |
| Machinability         | No          |
| Deposit Layers        | 2           |
| Hot Wear Applications | Up to 800°F |

**ALLOY TYPE**

Eutectic Chromium Carbides in an Austenitic Matrix

**TYPICAL APPLICATIONS**

Typical applications include:

- Compactors
- Mill Hammers
- Buckets and Bucket Teeth
- Dredge Pumps

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

|                    |                   |                    |
|--------------------|-------------------|--------------------|
| Diameter, In. (mm) | <b>1/8 (3.2)</b>  | <b>5/32 (4.0)</b>  |
| Current, Amp. DCRP | 90 – 130          | 120 – 160          |
| Position           | Flat              | Flat               |
| <br>               |                   |                    |
| Diameter, In. (mm) | <b>3/16 (4.8)</b> | <b>1/4" (6.4")</b> |
| Current, Amp. DCRP | 140 – 220         | 175 – 300          |
| Position           | Flat              | Flat               |

**STANDARD SIZES & PACKAGING**

| <u>Diameter</u> | <u>Packaging</u> | <u>Part #</u> |
|-----------------|------------------|---------------|
| 1/8" (3.2mm)    | 10# Box          | 11172700      |
| 1/8" (3.2mm)    | 50# Bulk Pak     | 10205200      |
| 5/32" (4.0mm)   | 10# Box          | 11172900      |
| 5/32" (4.0mm)   | 50# Bulk Pak     | 10205600      |
| 3/16" (4.8mm)   | 10# Box          | 11173000      |
| 3/16" (4.8mm)   | 50# Bulk Pak     | 10205700      |
| 1/4" (6.4mm)    | 10# Box          | 11173100      |
| 1/4" (6.4mm)    | 50# Bulk Pak     | 10205800      |