

DESCRIPTION

Stoody 1105 LH is a solid core electrode designed for wear resistance in metal-to-metal applications. It has an extruded coating containing the alloying elements. It provides good weldability and a high deposition rate. It bonds readily to carbon and low alloy steels and is not recommended for manganese steels or cast irons. It is forgeable at red heat.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Moderate
Impact Resistance	Moderate
Hardness on 1045 Steel	HRC 38 – 42
Magnetic	Yes
Surface Cross Checks	No
Machinability	Yes
Deposit Layers	Up to 4
Hot Wear Applications	Up to 600°F

ALLOY TYPE

Low Alloy Steel

TYPICAL APPLICATIONS

Typical applications include:

- Tractor Rollers and Idlers
- Shovel Roller and Idlers
- Drive Tumblers
- Charging Car Wheels
- Arch Wheels
- Sprockets
- Churn Drills
- Wobblers

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DCRP	80 – 150	140 – 210
Position	Flat	Flat
Length	14"	14"

Diameter, In. (mm)	3/16 (4.8)
Current, Amp. DCRP	165 – 250
Position	Flat
Length	14"

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
1/8" (3.2mm)	10# Vac Pak	11345100
5/32" (4.0mm)	10# Vac Pak	11173800
3/16" (4.8mm)	10# Vac Pak	11173900